

UNITED STATES PATENT APPLICATION FOR:

**ACTIVATED CATALYST SYSTEMS
FROM SUBSTITUTED DIALUMINOXANE COMPLEXES**


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ATTORNEY DOCKET NUMBER: 2001-017 (UNIV/0017)

CERTIFICATION OF MAILING UNDER 37 C.F.R. 1.10

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ACTIVATED CATALYST SYSTEMS FROM SUBSTITUTED DIALUMINOXANE COMPLEXES

BACKGROUND OF THE INVENTION

Field of the Invention

[0001] Embodiments of the present invention generally relate to the preparation of supported catalysts for olefin polymerization. More particularly, embodiments of the present invention relate to supported dialuminoxane complexes capable of providing stable polymerization catalysts.

Description of the Related Art

[0002] Polymerization catalyst compounds are typically combined with an activator, also referred to as a co-catalyst, to form compositions having a vacant coordination site that will coordinate, insert, and polymerize olefins. Metallocene polymerization catalysts, for example, are typically activated with aluminoxanes. Aluminoxanes are generally oligomeric compounds containing -Al(R)-O- subunits, where R is an alkyl group. One common and widely used aluminoxane is methylaluminoxane (MAO).

[0003] There are several disadvantages to using MAO as an activator, however. First, the synthesis of MAO requires a complicated process. A typical synthesis includes the controlled hydrolysis of trimethylaluminum (TMA). This process must be precisely controlled to reduce losses of aluminum to insoluble species. Second, the starting material TMA is expensive and thus necessarily, the end product MAO is expensive. Third, a huge excess of MAO is needed relative to the metallocene to sufficiently activate the metallocene. Fourth, MAO has very low solubility in aliphatic solvents, which leads to poor storage stability since MAO tends to precipitates out of solution over time. Therefore, MAO is not a cost effective activator due to its problems of low yield, poor solubility, poor storage stability, and expensive reagents.

[0004] Alternative activators for metallocenes and other single-site polymerization catalysts have been discovered in recent years. For example, perfluorophenyl aluminum and perfluorophenyl boron complexes have been used. In EP 0 427 697 and EP 0 520 732,

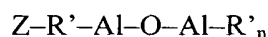
tris(perfluorophenyl)borane was described as being capable of abstracting a ligand from cyclopentadienyl derivatives of transition metals while providing a stabilizing, compatible noncoordinating anion. However, the catalyst activity was not impressive.

[0005] There is a need, therefore, to provide a simpler method of co-catalyst synthesis and catalyst activation. There is also a need to improve catalyst economics by providing a highly active supported co-catalyst.

SUMMARY OF THE INVENTION

[0006] A catalyst composition and method for preparing a supported catalyst system for olefin polymerization is provided. In one aspect, the catalyst composition includes a reaction product of a dialuminoxane and a halogen substituted aryl borane, wherein the reaction takes place on a support and at conditions sufficient to exchange one or more ligands on the dialuminoxane for one or more ligands on the halogen substituted aryl borane while on the support. In one embodiment, the method for preparing the supported catalyst system includes combining a dialuminoxane with a support to form a treated catalyst support, and combining a halogen substituted aryl borane with the treated catalyst support at conditions sufficient to exchange one or more ligands on the dialuminoxane for one or more ligands on the halogen substituted aryl borane while on the support to form a supported activator. The method further includes reacting one or more polymerization catalysts with the supported activator.

[0007] In another embodiment, the method for preparing the supported catalyst system includes combining a dialuminoxane with a support to form a treated catalyst support, combining a halogen substituted aryl borane with the treated catalyst support at conditions sufficient to exchange one or more ligands on the dialuminoxane for one or more ligands on the halogen substituted aryl borane while on the support to form a supported activator represented by the formula:



wherein Z is a polymeric support, R' is independently selected from an alkyl group having 1-20 carbon atoms and an aryl halogen group, and n is 2. The method further includes reacting one or more polymerization catalysts with the supported activator.

[0008] The one or more polymerization catalysts is represented by the formula:

[0009] $Cp^A Cp^B MX_n$

[0010] wherein:

[0011] M is a metal atom;

[0012] Cp^A and Cp^B are each independently an unsubstituted or substituted cyclic ring group;

[0013] X is a leaving group, and

[0014] n is zero or an integer from 1 to 4.

[0015] A method for olefin polymerization is also provided. In one aspect, the method includes combining a dialuminoxane with a support to form a treated catalyst support, and combining a halogen substituted aryl borane with the treated catalyst support at conditions sufficient to exchange one or more ligands on the dialuminoxane for one or more ligands on the halogen substituted aryl borane while on the support to form a supported activator. The method also includes reacting the supported activator with a polymerization catalyst to form a supported catalyst system, introducing the supported catalyst system and one or more monomers into a reactor, and polymerizing the one or more monomers within the reactor to form a polymer product.

DETAILED DESCRIPTION

[0016] A less expensive and cost efficient method for making a catalyst activator containing both aluminum and boron atoms is provided. In one aspect, the catalyst activator is a reaction product of one or more halogen substituted aryl boranes and one or more dialuminoxanes. The reaction of the one or more halogen substituted aryl boranes and the

one or more dialuminoxanes takes place on a catalyst support or carrier and takes place at conditions sufficient to facilitate an exchange of ligands on the reagents.

[0017] More particularly, the one or more dialuminoxanes are first supported on the catalyst support prior to contact with the one or more halogen substituted aryl boranes. The reaction conditions are such that one or more ligands on the dialuminoxanes are exchanged for one or more ligands on the halogen substituted aryl boranes while on the support. For purposes of this application, the term "supported" means deposited on, contacted with, vaporized with, bonded to, or incorporated within, adsorbed or absorbed in, or on.

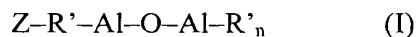
[0018] The reaction conditions that facilitate the ligand exchange typically include temperatures less than about 250°C at atmospheric pressure. In one aspect, the reaction temperature is from about 50°C to about 200°C. In another aspect, the reaction temperature is from about 75°C to about 150°C. In yet another aspect, the reaction temperature is from about 100°C to about 130°C.

[0019] The one or more halogen substituted aryl boranes are typically added to the one or more dialuminoxanes to yield a particular molar ratio of aluminum atoms to boron atoms. In one aspect, the molar ratio of aluminum atoms to boron atoms is at least 1:1 and up to 100:1. In another aspect, the molar ratio of aluminum atoms to boron atoms is from about 3:1 to about 50:1. In yet another aspect, the molar ratio of aluminum atoms to boron atoms is from about 5:1 to about 25:1.

[0020] The one or more halogen substituted aryl boranes may include organoboranes having one or more alkyl, aryl, arylalkyl groups, or any combination thereof attached thereto. Some specific examples include substituted and unsubstituted trialkylboranes and triarylboranes, such as trisperfluorophenylborane, tris(pentafluorophenyl)borane, triphenylborane, tris(2,3,5,6-tetrafluorophenyl)borane, tris(2,3,4,5-tetrafluorophenyl)borane, tris(3,4,5-trifluorophenyl)borane, tris(1,2,2-trifluoroethenyl)borane, phenylbis(perfluorophenyl)borane, tri-n-octylborane, combinations thereof, and derivatives thereof. Preferably, the one or more halogen substituted aryl boranes include trisperfluorophenylborane.

[0021] The one or more dialuminoxanes may include oligomeric compounds containing $[-Al(R)_2-O-]_n$ or $[-(R_2-Al)_2-O-]_n$ subunits, where R is an alkyl or cycloalkyl group having 1 to 20 carbon atoms and n is an integer from 1 to 5. Examples of these aluminoxanes include tetraethyldialuminoxane, di-isobutylaluminoxane, di-octylaluminoxane, di-butylaluminoxane, and di-t-butylaluminoxane. There are a variety of methods for preparing dialuminoxane and modified dialuminoxanes, such as the methods described in U.S. Patent No. 4,542,199, 4,960,878, and Eugene You-Xian Chen & Tobin J. Marks, *Cocatalysts for Metal-Catalyzed Olefin Polymerization: Activators, Activation Processes, and Structure-Activity Relationships*, 100 CHEM. REV. 1391-1434 (2000).

[0022] In one aspect, the supported catalyst activator is represented by the formula:



wherein: Z is a metal/metalloid oxide or polymeric support; R' is independently selected from an alkyl group having 1-20 carbon atoms and an aryl halogen (ArHal) group; and n is 2. Preferably, the aryl halogen group is a halogenated C₆ or higher carbon number polycyclic aromatic hydrocarbon or aromatic ring assembly in which two or more rings or fused ring systems are joined directly to one another or together. The use of the terms "halogenated" or "halogenation" for the purposes of this application means that at least one third of hydrogen atoms on carbon atoms of the aryl-substituted aromatic ligands are replaced by halogen atoms, and more preferred that the aromatic ligands be perhalogenated. Examples of aryl groups include phenyl, naphthyl, anthracenyl, and biphenyl radicals. Exemplary halogens include fluorine, bromine, chlorine and iodine. Fluorine is a more preferred halogen.

[0023] The term "activator" as used herein refers to any compound or component, or combination of compounds or components, capable of enhancing the ability of a catalyst to polymerize olefin monomers to form polyolefins. The term "catalyst" is used interchangeably with the term "catalyst component", and includes any compound or component, or combination of compounds or components, that is capable of increasing the rate of a chemical reaction, such as the polymerization or oligomerization of one or more olefins. The term "catalyst system" as used herein includes at least one "catalyst" and at least one "activator". The "catalyst system" may also include other components, such as a

support for example. The catalyst system may include any number of catalysts in any combination as described herein, as well as any activator in any combination as described herein.

Catalyst Compositions

[0024] The catalyst activators described above may be utilized in conjunction with any suitable polymerization catalyst to form the supported catalyst system. Exemplary polymerization catalysts include metallocenes, Group 15 containing compounds, phenoxide transition metal compositions, Group 5 or 6 metal imido complexes, bridged bis(arylamido) Group 4 compounds, derivatives thereof, and combinations thereof. Typically, the mole ratio of the metal of the activator to the metal of the catalyst compound is in the range of between 0.3:1 to 10,000:1, preferably 100:1 to 5000:1, and most preferably 500:1 to 2000:1. Some exemplary polymerization catalysts are discussed in more detail below.

Metallocene Catalyst Compositions

[0025] The catalyst system may include at least one metallocene catalyst component. The metallocene catalyst component may include "half sandwich" and "full sandwich" compounds having one or more Cp ligands (cyclopentadienyl and ligands isolobal to cyclopentadienyl) bound to at least one Group 3 to Group 12 metal atom, and one or more leaving group(s) bound to the at least one metal atom. Hereinafter, these compounds will be referred to as "metallocenes" or "metallocene catalyst components". The metallocene catalyst component is supported on a support material in a particular embodiment as described further below, and may be supported with or without another catalyst component.

[0026] The Cp ligands are one or more rings or ring system(s), at least a portion of which includes π -bonded systems, such as cycloalkadienyl ligands and heterocyclic analogues. The ring(s) or ring system(s) typically comprise atoms selected from the group consisting of Groups 13 to 16 atoms, and more particularly, the atoms that make up the Cp ligands are selected from the group consisting of carbon, nitrogen, oxygen, silicon, sulfur, phosphorous, germanium, boron and aluminum and combinations thereof, wherein carbon makes up at least 50% of the ring members. Even more particularly, the Cp ligand(s) are selected from the group consisting of substituted and unsubstituted cyclopentadienyl ligands and ligands

isolobal to cyclopentadienyl, non-limiting examples of which include cyclopentadienyl, indenyl, fluorenyl and other structures. Further non-limiting examples of such ligands include cyclopentadienyl, cyclopentaphenanthrenyl, indenyl, benzindenyl, fluorenyl, octahydrofluorenyl, cyclooctatetraenyl, cyclopentacyclododecene, phenanthrindenyl, 3,4-benzofluorenyl, 9-phenylfluorenyl, 8-H-cyclopent[a]acenaphthylenyl, 7H-dibenzofluorenyl, indeno[1,2-9]anthrene, thiophenoindenyl, thiophenofluorenyl, hydrogenated versions thereof (*e.g.*, 4,5,6,7-tetrahydroindenyl, or “H₄Ind”), substituted versions thereof (as described in more detail below), and heterocyclic versions thereof.

[0027] The metal atom “M” of the metallocene catalyst compound, as described throughout the specification and claims, may be selected from the group consisting of Groups 3 through 12 atoms and lanthanide Group atoms in one embodiment; and selected from the group consisting of Groups 3 through 10 atoms in a more particular embodiment, and selected from the group consisting of Sc, Ti, Zr, Hf, V, Nb, Ta, Mn, Re, Fe, Ru, Os, Co, Rh, Ir, and Ni in yet a more particular embodiment; and selected from the group consisting of Groups 4, 5 and 6 atoms in yet a more particular embodiment, and a Ti, Zr, Hf atoms in yet a more particular embodiment, and Zr in yet a more particular embodiment. The oxidation state of the metal atom “M” may range from 0 to +7 in one embodiment; and in a more particular embodiment, is +1, +2, +3, +4 or +5; and in yet a more particular embodiment is +2, +3 or +4. The groups bound the metal atom “M” are such that the compounds described below in the formulas and structures are neutral, unless otherwise indicated. The Cp ligand(s) form at least one chemical bond with the metal atom M to form the “metallocene catalyst compound”. The Cp ligands are distinct from the leaving groups bound to the catalyst compound in that they are not highly susceptible to substitution/abstraction reactions.

[0028] In one aspect, the one or more metallocene catalyst components are represented by the formula (II):



[0030] wherein M is as described above; each X is chemically bonded to M; each Cp group is chemically bonded to M; and n is 0 or an integer from 1 to 4, and either 1 or 2 in a particular embodiment.

[0031] The ligands represented by Cp^A and Cp^B in formula (II) may be the same or different cyclopentadienyl ligands or ligands isolobal to cyclopentadienyl, either or both of which may contain heteroatoms and either or both of which may be substituted by a group R. In one embodiment, Cp^A and Cp^B are independently selected from the group consisting of cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, and substituted derivatives of each.

[0032] Independently, each Cp^A and Cp^B of formula (II) may be unsubstituted or substituted with any one or combination of substituent groups R. Non-limiting examples of substituent groups R as used in structure (II) include hydrogen radicals, alkyls, alkenyls, alkynyls, cycloalkyls, aryls, acyls, aroyls, alkoxys, aryloxys, alkylthiols, dialkylamines, alkylamidos, alkoxycarbonyls, aryloxycarbonyls, carbomoyls, alkyl- and dialkyl-carbamoyls, acyloxys, acylaminos, aroylaminos, and combinations thereof.

[0033] More particular non-limiting examples of alkyl substituents R associated with formula (II) includes methyl, ethyl, propyl, butyl, pentyl, hexyl, cyclopentyl, cyclohexyl, benzyl, phenyl, methylphenyl, and tert-butylphenyl groups and the like, including all their isomers, for example tertiary-butyl, isopropyl, and the like. Other possible radicals include substituted alkyls and aryls such as, for example, fluoromethyl, fluoroethyl, difluoroethyl, iodopropyl, bromohexyl, chlorobenzyl and hydrocarbyl substituted organometalloid radicals including trimethylsilyl, trimethylgermyl, methyldiethylsilyl and the like; and halocarbyl-substituted organometalloid radicals including tris(trifluoromethyl)silyl, methylbis(difluoromethyl)silyl, bromomethyldimethylgermyl and the like; and disubstituted boron radicals including dimethylboron for example; and disubstituted Group 15 radicals including dimethylamine, dimethylphosphine, diphenylamine, methylphenylphosphine, Group 16 radicals including methoxy, ethoxy, propoxy, phenoxy, methylsulfide and ethylsulfide. Other substituents R include olefins such as but not limited to olefinically unsaturated substituents including vinyl-terminated ligands, for example 3-butenyl, 2-propenyl, 5-hexenyl and the like. In one embodiment, at least two R groups, two adjacent R

groups in one embodiment, are joined to form a ring structure having from 3 to 30 atoms selected from the group consisting of carbon, nitrogen, oxygen, phosphorous, silicon, germanium, aluminum, boron and combinations thereof. Also, a substituent group R group such as 1-butanyl may form a bonding association to the element M.

[0034] Each X in formula (II) is independently selected from the group consisting of: any leaving group in one embodiment; halogen ions, hydrides, C₁ to C₁₂ alkyls, C₂ to C₁₂ alkenyls, C₆ to C₁₂ aryls, C₇ to C₂₀ alkylaryls, C₁ to C₁₂ alkoxys, C₆ to C₁₆ aryloxys, C₇ to C₁₈ alkylaryloxys, C₁ to C₁₂ fluoroalkyls, C₆ to C₁₂ fluoroaryls, and C₁ to C₁₂ heteroatom-containing hydrocarbons and substituted derivatives thereof in a more particular embodiment; hydride, halogen ions, C₁ to C₆ alkyls, C₂ to C₆ alkenyls, C₇ to C₁₈ alkylaryls, C₁ to C₆ alkoxys, C₆ to C₁₄ aryloxys, C₇ to C₁₆ alkylaryloxys, C₁ to C₆ alkylcarboxylates, C₁ to C₆ fluorinated alkylcarboxylates, C₆ to C₁₂ arylcarboxylates, C₇ to C₁₈ alkylarylcarboxylates, C₁ to C₆ fluoroalkyls, C₂ to C₆ fluoroalkenyls, and C₇ to C₁₈ fluoroalkylaryls in yet a more particular embodiment; hydride, chloride, fluoride, methyl, phenyl, phenoxy, benzoxy, tosyl, fluoromethyls and fluorophenyls in yet a more particular embodiment; C₁ to C₁₂ alkyls, C₂ to C₁₂ alkenyls, C₆ to C₁₂ aryls, C₇ to C₂₀ alkylaryls, substituted C₁ to C₁₂ alkyls, substituted C₆ to C₁₂ aryls, substituted C₇ to C₂₀ alkylaryls and C₁ to C₁₂ heteroatom-containing alkyls, C₁ to C₁₂ heteroatom-containing aryls and C₁ to C₁₂ heteroatom-containing alkylaryls in yet a more particular embodiment; chloride, fluoride, C₁ to C₆ alkyls, C₂ to C₆ alkenyls, C₇ to C₁₈ alkylaryls, halogenated C₁ to C₆ alkyls, halogenated C₂ to C₆ alkenyls, and halogenated C₇ to C₁₈ alkylaryls in yet a more particular embodiment; fluoride, methyl, ethyl, propyl, phenyl, methylphenyl, dimethylphenyl, trimethylphenyl, fluoromethyls (mono-, di- and trifluoromethyls) and fluorophenyls (mono-, di-, tri-, tetra- and pentafluorophenyls) in yet a more particular embodiment.

[0035] Other non-limiting examples of X groups in formula (II) include amines, phosphines, ethers, carboxylates, dienes, hydrocarbon radicals having from 1 to 20 carbon atoms, fluorinated hydrocarbon radicals (*e.g.*, -C₆F₅ (pentafluorophenyl)), fluorinated alkylcarboxylates (*e.g.*, CF₃C(O)O⁻), hydrides and halogen ions and combinations thereof. Other examples of X ligands include alkyl groups such as cyclobutyl, cyclohexyl, methyl, heptyl, tolyl, trifluoromethyl, tetramethylene, pentamethylene, methyldiene, methoxy,

ethoxy, propoxy, phenoxy, bis(N-methylanilide), dimethylamide, dimethylphosphide radicals and the like. In one embodiment, two or more X's form a part of a fused ring or ring system.

[0036] In another aspect, the metallocene catalyst component includes those of formula (II) where Cp^{A} and Cp^{B} are bridged to each other by at least one bridging group, (A), such that the structure is represented by formula (III):



[0038] These bridged compounds represented by formula (III) are known as "bridged metallocenes". Cp^{A} , Cp^{B} , M, X and n are as defined above for formula (VI); and wherein each Cp ligand is chemically bonded to M, and (A) is chemically bonded to each Cp. Non-limiting examples of bridging group (A) include divalent hydrocarbon groups containing at least one Group 13 to 16 atom, such as but not limited to at least one of a carbon, oxygen, nitrogen, silicon, aluminum, boron, germanium and tin atom and combinations thereof; wherein the heteroatom may also be C_1 to C_{12} alkyl or aryl substituted to satisfy neutral valency. The bridging group (A) may also contain substituent groups R as defined above for formula (II) including halogen radicals and iron. More particular non-limiting examples of bridging group (A) are represented by C_1 to C_6 alkylenes, substituted C_1 to C_6 alkylenes, oxygen, sulfur, $\text{R}'_2\text{C}=\text{}$, $\text{R}'_2\text{Si}=\text{}$, $-\text{Si}(\text{R}')_2\text{Si}(\text{R}'_2)-$, $\text{R}'_2\text{Ge}=\text{}$, $\text{R}'\text{P}=\text{}$ (wherein "=" represents two chemical bonds), where R' is independently selected from the group consisting of hydride, hydrocarbyl, substituted hydrocarbyl, halocarbyl, substituted halocarbyl, hydrocarbyl-substituted organometalloid, halocarbyl-substituted organometalloid, disubstituted boron, disubstituted Group 15 atoms, substituted Group 16 atoms, and halogen radical; and wherein two or more R' may be joined to form a ring or ring system. In one embodiment, the bridged metallocene catalyst component of formula (III) has two or more bridging groups (A).

[0039] Other non-limiting examples of bridging group (A) include methylene, ethylene, ethylidene, propylidene, isopropylidene, diphenylmethylene, 1,2-dimethylethylene, 1,2-diphenylethylene, 1,1,2,2-tetramethylethylene, dimethylsilyl, diethylsilyl, methyl-ethylsilyl, trifluoromethylbutylsilyl, bis(trifluoromethyl)silyl, di(n-butyl)silyl, di(n-propyl)silyl, di(i-

propyl)silyl, di(n-hexyl)silyl, dicyclohexylsilyl, diphenylsilyl, cyclohexylphenylsilyl, t-butylcyclohexylsilyl, di(t-butylphenyl)silyl, di(p-tolyl)silyl and the corresponding moieties wherein the Si atom is replaced by a Ge or a C atom; dimethylsilyl, diethylsilyl, dimethylgermyl and diethylgermyl.

[0040] In another embodiment, bridging group (A) may also be cyclic, comprising, for example 4 to 10, 5 to 7 ring members in a more particular embodiment. The ring members may be selected from the elements mentioned above, from one or more of B, C, Si, Ge, N and O in a particular embodiment. Non-limiting examples of ring structures which may be present as or part of the bridging moiety are cyclobutylidene, cyclopentylidene, cyclohexylidene, cycloheptylidene, cyclooctylidene and the corresponding rings where one or two carbon atoms are replaced by at least one of Si, Ge, N and O, in particular, Si and Ge. The bonding arrangement between the ring and the Cp groups may be either cis-, trans-, or a combination.

[0041] The cyclic bridging groups (A) may be saturated or unsaturated and/or carry one or more substituents and/or be fused to one or more other ring structures. If present, the one or more substituents are selected from the group consisting of hydrocarbyl (*e.g.*, alkyl such as methyl) and halogen (*e.g.*, F, Cl) in one embodiment. The one or more Cp groups which the above cyclic bridging moieties may optionally be fused to may be saturated or unsaturated and are selected from the group consisting of those having 4 to 10, more particularly 5, 6 or 7 ring members (selected from the group consisting of C, N, O and S in a particular embodiment) such as, for example, cyclopentyl, cyclohexyl and phenyl. Moreover, these ring structures may themselves be fused such as, for example, in the case of a naphthyl group. Moreover, these (optionally fused) ring structures may carry one or more substituents. Illustrative, non-limiting examples of these substituents are hydrocarbyl (particularly alkyl) groups and halogen atoms.

[0042] The ligands Cp^A and Cp^B of formula (II) and (III) are different from each other in one embodiment, and the same in another embodiment.

[0043] In yet another aspect, the metallocene catalyst components include mono-ligand metallocene compounds (*e.g.*, mono cyclopentadienyl catalyst components) such as

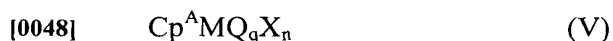
described in WO 93/08221 for example. In this embodiment, the at least one metallocene catalyst component is a bridged "half-sandwich" metallocene represented by the formula (IV):



[0045] wherein Cp^{A} is defined above and is bound to M; (A) is a bridging group bonded to Q and Cp^{A} ; and wherein an atom from the Q group is bonded to M; and n is 0 or an integer from 1 to 3; 1 or 2 in a particular embodiment. In formula (IV), Cp^{A} , (A) and Q may form a fused ring system. The X groups and n of formula (IV) are as defined above in formula (II) and (III). In one embodiment, Cp^{A} is selected from the group consisting of cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, substituted versions thereof, and combinations thereof.

[0046] In formula (IV), Q is a heteroatom-containing ligand in which the bonding atom (the atom that is bonded with the metal M) is selected from the group consisting of Group 15 atoms and Group 16 atoms in one embodiment, and selected from the group consisting of nitrogen, phosphorus, oxygen or sulfur atom in a more particular embodiment, and nitrogen and oxygen in yet a more particular embodiment. Non-limiting examples of Q groups include alkylamines, arylamines, mercapto compounds, ethoxy compounds, carboxylates (e.g., pivalate), carbamates, azenyl, azulene, pentalene, phosphoyl, phosphinimine, pyrrolyl, pyrozolyl, carbazolyl, borabenzene other compounds comprising Group 15 and Group 16 atoms capable of bonding with M.

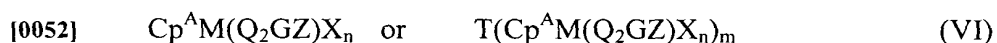
[0047] In yet another aspect, the at least one metallocene catalyst component is an unbridged "half sandwich" metallocene represented by the formula (V):



[0049] wherein Cp^{A} is defined as for the Cp groups in (II) and is a ligand that is bonded to M; each Q is independently bonded to M; Q is also bound to Cp^{A} in one embodiment; X is a leaving group as described above in (II); n ranges from 0 to 3, and is 1 or 2 in one embodiment; q ranges from 0 to 3, and is 1 or 2 in one embodiment. In one embodiment, Cp^{A} is selected from the group consisting of cyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, substituted version thereof, and combinations thereof.

[0050] In formula (V), Q is selected from the group consisting of ROO^- , $\text{RO}-$, $\text{R(O)}-$, $-\text{NR}-$, $-\text{CR}_2-$, $-\text{S}-$, $-\text{NR}_2$, $-\text{CR}_3$, $-\text{SR}$, $-\text{SiR}_3$, $-\text{PR}_2$, $-\text{H}$, and substituted and unsubstituted aryl groups, wherein R is selected from the group consisting of C_1 to C_6 alkyls, C_6 to C_{12} aryls, C_1 to C_6 alkylamines, C_6 to C_{12} alkylarylamines, C_1 to C_6 alkoxys, C_6 to C_{12} aryloxys, and the like. Non-limiting examples of Q include C_1 to C_{12} carbamates, C_1 to C_{12} carboxylates (*e.g.*, pivalate), C_2 to C_{20} allyls, and C_2 to C_{20} heteroallyl moieties.

[0051] Described another way, the “half sandwich” metallocenes above can be described as in formula (III), such as described in, for example, US 6,069,213:



[0053] wherein M, Cp^{A} , X and n are as defined above;

[0054] Q_2GZ forms a polydentate ligand unit (*e.g.*, pivalate), wherein at least one of the Q groups form a bond with M, and is defined such that each Q is independently selected from the group consisting of $-\text{O}-$, $-\text{NR}-$, $-\text{CR}_2-$ and $-\text{S}-$; G is either carbon or silicon; and Z is selected from the group consisting of R, $-\text{OR}$, $-\text{NR}_2$, $-\text{CR}_3$, $-\text{SR}$, $-\text{SiR}_3$, $-\text{PR}_2$, and hydride, providing that when Q is $-\text{NR}-$, then Z is selected from the group consisting of $-\text{OR}$, $-\text{NR}_2$, $-\text{SR}$, $-\text{SiR}_3$, $-\text{PR}_2$; and provided that neutral valency for Q is satisfied by Z; and wherein each R is independently selected from the group consisting of C_1 to C_{10} heteroatom containing groups, C_1 to C_{10} alkyls, C_6 to C_{12} aryls, C_6 to C_{12} alkylaryls, C_1 to C_{10} alkoxys, and C_6 to C_{12} aryloxys;

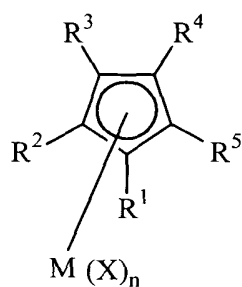
[0055] n is 1 or 2 in a particular embodiment; and

[0056] T is a bridging group selected from the group consisting of C_1 to C_{10} alkylenes, C_6 to C_{12} arylenes and C_1 to C_{10} heteroatom containing groups, and C_6 to C_{12} heterocyclic groups; wherein each T group bridges adjacent “ $\text{Cp}^{\text{A}}\text{M}(\text{Q}_2\text{GZ})\text{X}_n$ ” groups, and is chemically bonded to the Cp^{A} groups.

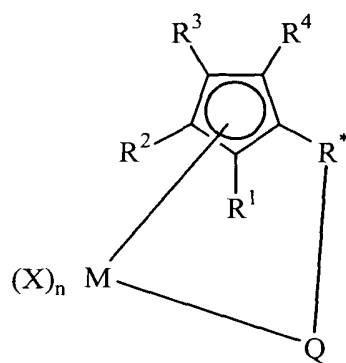
[0057] m is an integer from 1 to 7; m is an integer from 2 to 6 in a more particular embodiment.

[0058] In another aspect, the at least one metallocene catalyst component can be described more particularly in structures (VIIa), (VIIb), (VIIc), (VIId), (VIIe), and (VIIf):

[0059]

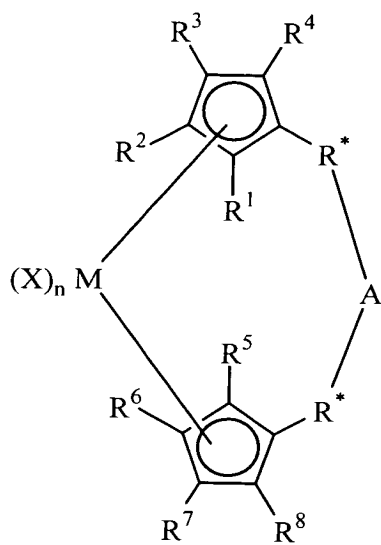


(VIIa-i)



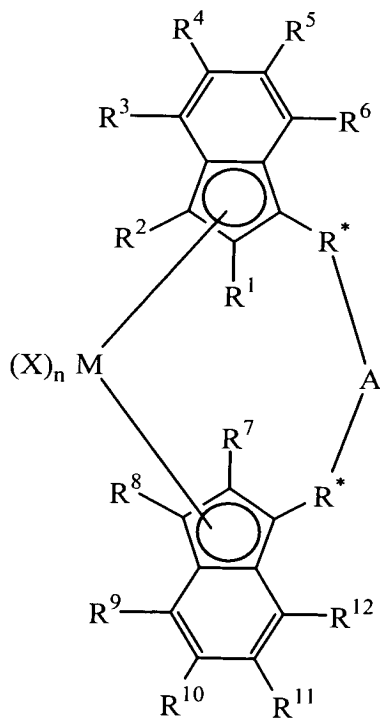
(VIIa-ii)

[0060]



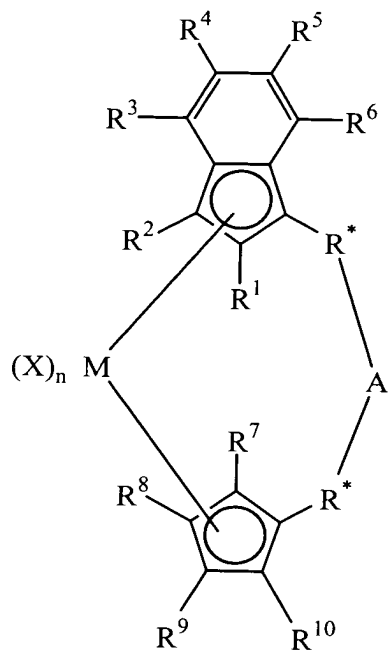
(VIIb)

[0061]



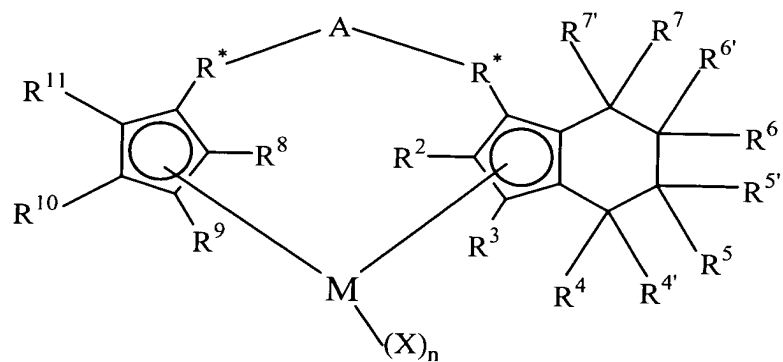
(VIIc)

[0062]



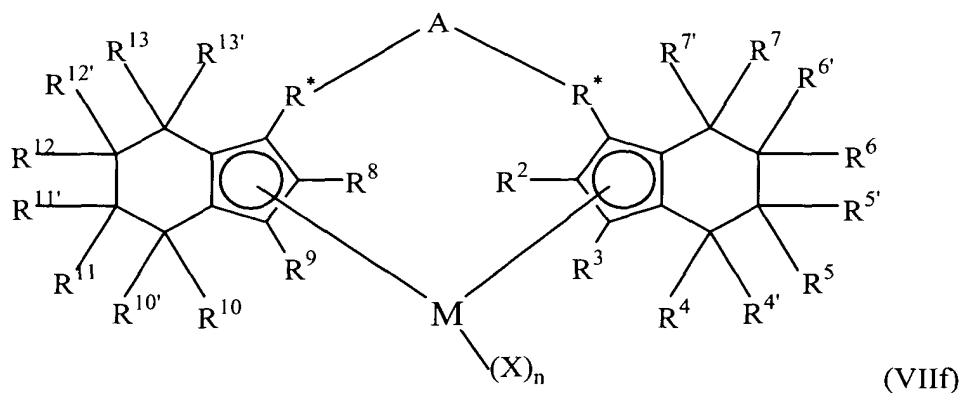
(VIIId)

[0063]



(VIIe)

[0064]



[0065] wherein in structures (VIIa) to (VIIf), M is selected from the group consisting of Group 3 to Group 12 atoms, and selected from the group consisting of Group 3 to Group 10 atoms in a more particular embodiment, and selected from the group consisting of Group 3 to Group 6 atoms in yet a more particular embodiment, and selected from the group consisting of Group 4 atoms in yet a more particular embodiment, and selected from the group consisting of Zr and Hf in yet a more particular embodiment; and is Zr in yet a more particular embodiment;

[0066] wherein Q in (VIIa) to (VIIf) is selected from the group consisting of alkylenes, aryls, arylenes, alkoxys, aryloxys, amines, arylamines (e.g., pyridyl) alkylamines, phosphines, alkylphosphines, substituted alkyls, substituted aryls, substituted alkoxys, substituted aryloxys, substituted amines, substituted alkylamines, substituted phosphines, substituted alkylphosphines, carbamates, heteroallyls, carboxylates (non-limiting examples of suitable carbamates and carboxylates include trimethylacetate, trimethylacetate, methylacetate, p-toluate, benzoate, diethylcarbamate, and dimethylcarbamate), fluorinated alkyls, fluorinated aryls, and fluorinated alkylcarboxylates; wherein the saturated groups defining Q comprise from 1 to 20 carbon atoms in one embodiment; and wherein the aromatic groups comprise from 5 to 20 carbon atoms in one embodiment;

[0067] wherein each R* is independently: selected from the group consisting of hydrocarbylenes and heteroatom-containing hydrocarbylenes in one embodiment; and selected from the group consisting of alkylenes, substituted alkylenes and heteroatom-

containing hydrocarbylenes in another embodiment; and selected from the group consisting of C₁ to C₁₂ alkylenes, C₁ to C₁₂ substituted alkylenes, and C₁ to C₁₂ heteroatom-containing hydrocarbylenes in a more particular embodiment; and selected from the group consisting of C₁ to C₄ alkylenes in yet a more particular embodiment; and wherein both R* groups are identical in another embodiment in structures (VII f);

[0068] A is as described above for (A) in structure (III), and more particularly, selected from the group consisting of a chemical bond, -O-, -S-, -SO₂-, -NR-, =SiR₂, =GeR₂, =SnR₂, -R₂SiSiR₂-, RP=, C₁ to C₁₂ alkylenes, substituted C₁ to C₁₂ alkylenes, divalent C₄ to C₁₂ cyclic hydrocarbons and substituted and unsubstituted aryl groups in one embodiment; and selected from the group consisting of C₅ to C₈ cyclic hydrocarbons, -CH₂CH₂-, =CR₂ and =SiR₂ in a more particular embodiment; wherein R is selected from the group consisting of alkyls, cycloalkyls, aryls, alkoxys, fluoroalkyls and heteroatom-containing hydrocarbons in one embodiment; and R is selected from the group consisting of C₁ to C₆ alkyls, substituted phenyls, phenyl, and C₁ to C₆ alkoxys in a more particular embodiment; and R is selected from the group consisting of methoxy, methyl, phenoxy, and phenyl in yet a more particular embodiment;

[0069] wherein A may be absent in yet another embodiment, in which case each R* is defined as for R¹-R¹³;

[0070] each X is as described above in (II);

[0071] n is an integer from 0 to 4, and from 1 to 3 in another embodiment, and 1 or 2 in yet another embodiment; and

[0072] R¹ through R¹³ are independently: selected from the group consisting of hydrogen radical, halogen radicals, C₁ to C₁₂ alkyls, C₂ to C₁₂ alkenyls, C₆ to C₁₂ aryls, C₇ to C₂₀ alkylaryl, C₁ to C₁₂ alkoxys, C₁ to C₁₂ fluoroalkyls, C₆ to C₁₂ fluoroaryl, and C₁ to C₁₂ heteroatom-containing hydrocarbons and substituted derivatives thereof in one embodiment; selected from the group consisting of hydrogen radical, fluorine radical, chlorine radical, bromine radical, C₁ to C₆ alkyls, C₂ to C₆ alkenyls, C₇ to C₁₈ alkylaryl, C₁ to C₆ fluoroalkyls, C₂ to C₆ fluoroalkenyls, C₇ to C₁₈ fluoroalkylaryl in a more particular

embodiment; and hydrogen radical, fluorine radical, chlorine radical, methyl, ethyl, propyl, isopropyl, butyl, isobutyl, tertiary butyl, hexyl, phenyl, 2,6-di-methylphey, and 4-tertiarybutylphey groups in yet a more particular embodiment; wherein adjacent R groups may form a ring, either saturated, partially saturated, or completely saturated.

[0073] The structure of the metallocene catalyst component represented by (XIa) may take on many forms such as disclosed in, for example, US 5,026,798, US 5,703,187, and US 5,747,406, including a dimer or oligomeric structure, such as disclosed in, for example, US 5,026,798 and US 6,069,213.

[0074] In a particular embodiment of the metallocene represented in (VIId), R^1 and R^2 form a conjugated 6-membered carbon ring system that may or may not be substituted.

[0075] Non-limiting examples of metallocene catalyst components consistent with the description herein include:

[0076] cyclopentadienylzirconium X_n ,

[0077] indenylzirconium X_n ,

[0078] (1-methylindenyl)zirconium X_n ,

[0079] (2-methylindenyl)zirconium X_n ,

[0080] (1-propylindenyl)zirconium X_n ,

[0081] (2-propylindenyl)zirconium X_n ,

[0082] (1-butylindenyl)zirconium X_n ,

[0083] (2-butylindenyl)zirconium X_n ,

[0084] (methylcyclopentadienyl)zirconium X_n ,

[0085] tetrahydroindenylzirconium X_n ,

[0086] (pentamethylcyclopentadienyl)zirconium X_n ,

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

- [0087] cyclopentadienylzirconium X_n ,
- [0088] pentamethylcyclopentadienyltitanium X_n ,
- [0089] tetramethylcyclopentyltitanium X_n ,
- [0090] 1,2,4-trimethylcyclopentadienylzirconium X_n ,
- [0091] dimethylsilyl(1,2,3,4-tetramethylcyclopentadienyl)(cyclopentadienyl)zirconium X_n ,
- [0092] dimethylsilyl(1,2,3,4-tetramethylcyclopentadienyl)(1,2,3-trimethylcyclopentadienyl)zirconium X_n ,
- [0093] dimethylsilyl(1,2,3,4-tetramethylcyclopentadienyl)(1,2-dimethylcyclopentadienyl)zirconium X_n ,
- [0094] dimethylsilyl(1,2,3,4-tetramethyl-cyclopentadienyl)(2-methylcyclopentadienyl)zirconium X_n ,
- [0095] dimethylsilyl(cyclopentadienyl)(indenyl)zirconium X_n ,
- [0096] dimethylsilyl(2-methylindenyl)(fluorenyl)zirconium X_n ,
- [0097] diphenylsilyl(1,2,3,4-tetramethyl-cyclopentadienyl)(3-propylcyclopentadienyl)zirconium X_n ,
- [0098] dimethylsilyl(1,2,3,4-tetramethylcyclopentadienyl)(3-t-butylcyclopentadienyl)zirconium X_n ,
- [0099] dimethylgermyl(1,2-dimethylcyclopentadienyl)(3-isopropylcyclopentadienyl)zirconium X_n ,
- [00100] dimethylsilyl(1,2,3,4-tetramethyl-cyclopentadienyl)(3-methylcyclopentadienyl)zirconium X_n ,
- [00101] diphenylmethylidene(cyclopentadienyl)(9-fluorenyl)zirconium X_n ,

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

- [00102] diphenylmethylenecyclopentadienylindenylzirconium X_n,
- [00103] iso-propylidenebis(cyclopentadienyl)zirconium X_n,
- [00104] iso-propylidene(cyclopentadienyl)(9-fluorenyl)zirconium X_n,
- [00105] iso-propylidene(3-methylcyclopentadienyl)(9-fluorenyl)zirconium X_n,
- [00106] ethylenebis(9-fluorenyl)zirconium X_n,
- [00107] meso-ethylenebis(1-indenyl)zirconium X_n,
- [00108] ethylenebis(1-indenyl)zirconium X_n,
- [00109] ethylenebis(2-methyl-1-indenyl)zirconium X_n,
- [00110] ethylenebis(2-methyl-4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00111] ethylenebis(2-propyl-4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00112] ethylenebis(2-isopropyl-4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00113] ethylenebis(2-butyl-4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00114] ethylenebis(2-isobutyl-4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00115] dimethylsilyl(4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00116] diphenyl(4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00117] ethylenebis(4,5,6,7-tetrahydro-1-indenyl)zirconium X_n,
- [00118] dimethylsilylbis(cyclopentadienyl)zirconium X_n,
- [00119] dimethylsilylbis(9-fluorenyl)zirconium X_n,
- [00120] dimethylsilylbis(1-indenyl)zirconium X_n,
- [00121] dimethylsilylbis(2-methylindenyl)zirconium X_n,

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

- [00122] dimethylsilylbis(2-propylindenyl)zirconium X_n ,
- [00123] dimethylsilylbis(2-butylindenyl)zirconium X_n ,
- [00124] diphenylsilylbis(2-methylindenyl)zirconium X_n ,
- [00125] diphenylsilylbis(2-propylindenyl)zirconium X_n ,
- [00126] diphenylsilylbis(2-butylindenyl)zirconium X_n ,
- [00127] dimethylgermylbis(2-methylindenyl)zirconium X_n
- [00128] dimethylsilylbis(tetrahydroindenyl)zirconium X_n ,
- [00129] dimethylsilylbis(tetramethylcyclopentadienyl)zirconium X_n ,
- [00130] dimethylsilyl(cyclopentadienyl)(9-fluorenyl)zirconium X_n ,
- [00131] diphenylsilyl(cyclopentadienyl)(9-fluorenyl)zirconium X_n ,
- [00132] diphenylsilylbis(indenyl)zirconium X_n ,
- [00133] cyclotrimethylenesilyl(tetramethylcyclopentadienyl)(cyclopentadienyl)zirconium X_n ,
- [00134] cyclotetramethylenesilyl(tetramethylcyclopentadienyl)(cyclopentadienyl)zirconium X_n ,
- [00135] cyclotrimethylenesilyl(tetramethylcyclopentadienyl)(2-methylindenyl)zirconium X_n ,
- [00136] cyclotrimethylenesilyl(tetramethylcyclopentadienyl)(3-methylcyclopentadienyl)zirconium X_n ,
- [00137] cyclotrimethylenesilylbis(2-methylindenyl)zirconium X_n ,
- [00138] cyclotrimethylenesilyl(tetramethylcyclopentadienyl)(2,3,5-trimethylcyclopentadienyl)zirconium X_n ,

- [00139] cyclotrimethylenesilylbis(tetramethylcyclopentadienyl)zirconium X_n ,
- [00140] dimethylsilyl(tetramethylcyclopentadienyl)(N-tert-butylamido)titanium X_n ,
- [00141] bis(cyclopentadienyl)chromium X_n ,
- [00142] bis(cyclopentadienyl)zirconium X_n ,
- [00143] bis(n-butylcyclopentadienyl)zirconium X_n ,
- [00144] bis(n-dodecylcyclopentadienyl)zirconium X_n ,
- [00145] bis(ethylcyclopentadienyl)zirconium X_n ,
- [00146] bis(iso-butylcyclopentadienyl)zirconium X_n ,
- [00147] bis(iso-propylcyclopentadienyl)zirconium X_n ,
- [00148] bis(methylcyclopentadienyl)zirconium X_n ,
- [00149] bis(n-octylcyclopentadienyl)zirconium X_n ,
- [00150] bis(n-pentylcyclopentadienyl)zirconium X_n ,
- [00151] bis(n-propylcyclopentadienyl)zirconium X_n ,
- [00152] bis(trimethylsilylcyclopentadienyl)zirconium X_n ,
- [00153] bis(1,3-bis(trimethylsilyl)cyclopentadienyl)zirconium X_n ,
- [00154] bis(1-ethyl-2-methylcyclopentadienyl)zirconium X_n ,
- [00155] bis(1-ethyl-3-methylcyclopentadienyl)zirconium X_n ,
- [00156] bis(pentamethylcyclopentadienyl)zirconium X_n ,
- [00157] bis(pentamethylcyclopentadienyl)zirconium X_n ,
- [00158] bis(1-propyl-3-methylcyclopentadienyl)zirconium X_n ,

- [00159] bis(1-n-butyl-3-methylcyclopentadienyl)zirconium X_n ,
- [00160] bis(1-isobutyl-3-methylcyclopentadienyl)zirconium X_n ,
- [00161] bis(1-propyl-3-butylcyclopentadienyl)zirconium X_n ,
- [00162] bis(1,3-n-butylcyclopentadienyl)zirconium X_n ,
- [00163] bis(4,7-dimethylindenyl)zirconium X_n ,
- [00164] bis(indenyl)zirconium X_n ,
- [00165] bis(2-methylindenyl)zirconium X_n ,
- [00166] cyclopentadienylindenylzirconium X_n ,
- [00167] bis(n-propylcyclopentadienyl)hafnium X_n ,
- [00168] bis(n-butylcyclopentadienyl)hafnium X_n ,
- [00169] bis(n-pentylcyclopentadienyl)hafnium X_n ,
- [00170] (n-propyl cyclopentadienyl)(n-butyl cyclopentadienyl)hafnium X_n ,
- [00171] bis[(2-trimethylsilyl)ethyl]cyclopentadienyl]hafnium X_n ,
- [00172] bis(trimethylsilyl cyclopentadienyl)hafnium X_n ,
- [00173] bis(2-n-propylindenyl)hafnium X_n ,
- [00174] bis(2-n-butylindenyl)hafnium X_n ,
- [00175] dimethylsilylbis(n-propylcyclopentadienyl)hafnium X_n ,
- [00176] dimethylsilylbis(n-butylcyclopentadienyl)hafnium X_n ,
- [00177] bis(9-n-propylfluorenyl)hafnium X_n ,
- [00178] bis(9-n-butylfluorenyl)hafnium X_n ,

- [00179] (9-n-propylfluorenyl)(2-n-propylindenyl)hafnium X_n ,
- [00180] bis(1-n-propyl-2-methylcyclopentadienyl)hafnium X_n ,
- [00181] (n-propylcyclopentadienyl)(1-n-propyl-3-n-butylcyclopentadienyl)hafnium X_n ,
- [00182] dimethylsilyl(tetramethylcyclopentadienyl)(cyclopropylamido)titanium X_n ,
- [00183] dimethylsilyl(tetramethylecyclopentadienyl)(cyclobutylamido)titanium X_n ,
- [00184] dimethylsilyl(tetramethylecyclopentadienyl)(cyclopentylamido)titanium X_n ,
- [00185] dimethylsilyl(tetramethylcyclopentadienyl)(cyclohexylamido)titanium X_n ,
- [00186] dimethylsilyl(tetramethylcyclopentadienyl)(cycloheptylamido)titanium X_n ,
- [00187] dimethylsilyl(tetramethylcyclopentadienyl)(cyclooctylamido)titanium X_n ,
- [00188] dimethylsilyl(tetramethylcyclopentadienyl)(cyclononylamido)titanium X_n ,
- [00189] dimethylsilyl(tetramethylcyclopentadienyl)(cyclodecylamido)titanium X_n ,
- [00190] dimethylsilyl(tetramethylcyclopentadienyl)(cycloundecylamido)titanium X_n ,
- [00191] dimethylsilyl(tetramethylcyclopentadienyl)(cyclododecylamido)titanium X_n ,
- [00192] dimethylsilyl(tetramethylcyclopentadienyl)(sec-butylamido)titanium X_n ,
- [00193] dimethylsilyl(tetramethylcyclopentadienyl)(n-octylamido)titanium X_n ,
- [00194] dimethylsilyl(tetramethylcyclopentadienyl)(n-decylamido)titanium X_n ,
- [00195] dimethylsilyl(tetramethylcyclopentadienyl)(n-octadecylamido)titanium X_n ,
- [00196] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclopropylamido)titanium X_n ,
- [00197] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclobutylamido)titanium X_n ,
- [00198] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclopentylamido)titanium X_n ,

- [00199] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclohexylamido)titanium X_n ,
- [00200] methylphenylsilyl(tetramethylcyclopentadienyl)(cycloheptylamido)titanium X_n ,
- [00201] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclooctylamido)titanium X_n ,
- [00202] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclononylamido)titanium X_n ,
- [00203] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclodecylamido)titanium, X_n ,
- [00204] methylphenylsilyl(tetramethylcyclopentadienyl)(cycloundecylamido)titanium X_n ,
- [00205] methylphenylsilyl(tetramethylcyclopentadienyl)(cyclododecylamido)titanium X_n ,
- [00206] methylphenylsilyl(tetramethylcyclopentadienyl)(sec-butylamido)titanium X_n ,
- [00207] methylphenylsilyl(tetramethylcyclopentadienyl)(n-octylamido)titanium X_n ,
- [00208] methylphenylsilyl(tetramethylcyclopentadienyl)(n-decylamido)titanium X_n ,
- [00209] methylphenylsilyl(tetramethylcyclopentadienyl)(n-octadecylamido)titanium X_n ,
- [00210] diphenylsilyl(tetramethylcyclopentadienyl)(cyclopropylamido)titanium X_n ,
- [00211] diphenylsilyl(tetramethylcyclopentadienyl)(cyclobutylamido)titanium X_n ,
- [00212] diphenylsilyl(tetramethylcyclopentadienyl)(cyclopentylamido)titanium X_n ,
- [00213] diphenylsilyl(tetramethylcyclopentadienyl)(cyclohexylamido)titanium X_n ,
- [00214] diphenylsilyl(tetramethylcyclopentadienyl)(cycloheptylamido)titanium X_n ,
- [00215] diphenylsilyl(tetramethylcyclopentadienyl)(cyclooctylamido)titanium X_n ,
- [00216] diphenylsilyl(tetramethylcyclopentadienyl)(cyclononylamido)titanium X_n ,
- [00217] diphenylsilyl(tetramethylcyclopentadienyl)(cyclodecylamido)titanium X_n ,
- [00218] diphenylsilyl(tetramethylcyclopentadienyl)(cycloundecylamido)titanium X_n ,

[00219] diphenylsilyl(tetramethylcyclopentadienyl)(cyclododecylamido)titanium X_n,

[00220] diphenylsilyl(tetramethylcyclopentadienyl)(sec-butylamido)titanium X_n,

[00221] diphenylsilyl(tetramethyleyclopentadienyl)(n-octylamido)titanium X_n,

[00222] diphenylsilyl(tetramethyleyclopentadienyl)(n-decylamido)titanium X_n,

[00223] diphenylsilyl(tetramethylcyclopentadienyl)(n-octadecylamido)titanium X_n,

[00224] and derivatives thereof.

[00225] By “derivatives thereof”, it is meant any substitution or ring formation as described above; and in particular, replacement of the metal “M” (Cr, Zr, Ti or Hf) with an atom selected from the group consisting of Cr, Zr, Hf and Ti; and replacement of the “X” group with any of C₁ to C₅ alkyls, C₆ aryls, C₆ to C₁₀ alkylaryls, fluorine or chlorine; n is 1, 2 or 3.

[00226] It is contemplated that the metallocene catalysts components described above include their structural or optical or enantiomeric isomers (racemic mixture), and may be a pure enantiomer in one embodiment.

[00227] As used herein, a single, bridged, asymmetrically substituted metallocene catalyst component having a racemic and/or meso isomer does not, itself, constitute at least two different bridged, metallocene catalyst components.

[00228] The “metallocene catalyst component” may comprise any combination of any “embodiment” described herein.

Group 15-Containing Catalyst Compositions

[00229] “Group 15-containing catalyst components”, as referred to herein, include Group 3 to Group 12 metal complexes, wherein the metal is 2 to 4 coordinate, the coordinating moiety or moieties including at least two Group 15 atoms, and up to four Group 15 atoms. In one embodiment, the Group 15-containing catalyst component is a complex of a Group 4 metal and from one to four ligands such that the Group 4 metal is at least 2 coordinate, the

coordinating moiety or moieties including at least two nitrogens. Representative Group 15-containing compounds are disclosed in, for example, WO 98/46651, WO 99/01460; EP A1 0 893,454; EP A1 0 894 005; US 5,318,935; US 5,889,128 US 6,333,389 B2 and US 6,271,325 B1.

[00230] In one embodiment, the Group 15-containing catalyst components may include Group 4 imino-phenol complexes, Group 4 bis(amide) complexes, and Group 4 pyridyl-amide complexes that are active towards olefin polymerization to any extent.

[00231] The Group 15-containing catalyst component may be more particularly described by the following formula (VIII):



[00232] wherein β and γ are groups that each comprise at least one Group 14 to Group 16 atom; and β (when present) and γ are groups bonded to M through between 2 and 6 Group 14 to Group 16 atoms, at least two atoms being Group 15-containing atoms.

[00233] More particularly, β and γ are groups selected from Group 14 and Group 15-containing: alkyls, aryls, alkylaryls, and heterocyclic hydrocarbons, and chemically bonded combinations thereof in one embodiment; and selected from Group 14 and Group 15-containing: C₁ to C₁₀ alkyls, C₆ to C₁₂ aryls, C₆ to C₁₈ alkylaryls, and C₄ to C₁₂ heterocyclic hydrocarbons, and chemically bonded combinations thereof in a more particular embodiment; and selected from C₁ to C₁₀ alkylamines, C₁ to C₁₀ alkoxys, C₆ to C₂₀ alkylarylamines, C₆ to C₁₈ alkylaryloxys, and C₄ to C₁₂ nitrogen containing heterocyclic hydrocarbons, and C₄ to C₁₂ alkyl substituted nitrogen containing heterocyclic hydrocarbons and chemically bonded combinations thereof in yet a more particular embodiment; and selected from anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, indolylns, C₁ to C₆ alkyl substituted groups selected from anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, indolylns; C₁ to C₆ alkylamine substituted groups selected from anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls,

indolyls, amine substituted anilinylns, pyridyls, quinolyls, pyrrolyls, pyrimidyls, purinyls, imidazyls, and indolyls; hydroxy substituted groups selected from anilinylns, pyridyls, quinolyls, pyrrolyls, pyrimidyls, purinyls, imidazyls, and indolyls; methyl-substituted phenylamines, and chemically bonded combinations thereof in yet a more particular embodiment;

[00234] α is a linking (or “bridging”) moiety that, when present, forms a chemical bond to each of β and γ , or two γ ’s, thus forming a “ $\gamma\alpha\gamma$ ” or “ $\gamma\alpha\beta$ ” ligand bound to M; α may also comprise a Group 14 to Group 16 atom which may be bonded to M through the Group 14 to Group 16 atom in one embodiment; and more particularly, α is a divalent bridging group selected from alkylenes, arylenes, alkenylenes, heterocyclic arylenes, alkylarylenes, heteroatom containing alkylenes, heteroatom containing alkenylenes and heterocyclic hydrocarbonylenes in one embodiment; and selected from C_1 to C_{10} alkylenes, C_2 to C_{10} alkenylenes, C_6 to C_{12} arylenes, C_1 to C_{10} divalent ethers, C_6 to C_{12} O- or N-containing arylenes, C_2 to C_{10} alkyleneamines, C_6 to C_{12} aryleneamines, and substituted derivatives thereof in yet a more particular embodiment;

[00235] a is an integer from 0 to 2; a is either 0 or 1 in a more particular embodiment; and a is 1 in yet a more particular embodiment; b is an integer from 0 to 2; g is an integer from 1 to 2; wherein in one embodiment, a is 1, b is 0 and g is 2; M is selected from Group 3 to Group 12 atoms in one embodiment; and selected from Group 3 to Group 10 atoms in a more particular embodiment; and selected from Group 3 to Group 6 atoms in yet a more particular embodiment; and selected from Ni, Cr, Ti, Zr and Hf in yet a more particular embodiment; and selected from Zr and Hf in yet a more particular embodiment; each X is as defined above; and n is an integer from 0 to 4 in one embodiment; and an integer from 1 to 3 in a more particular embodiment; and an integer from 2 to 3 in yet a more particular embodiment.

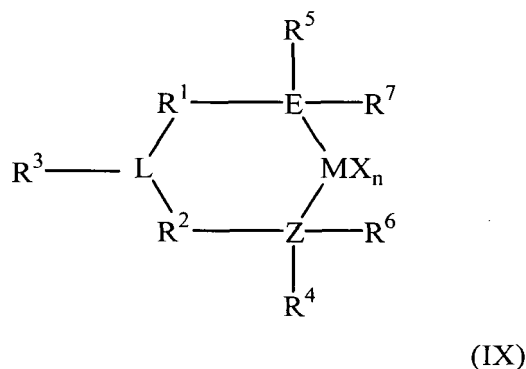
[00236] As used herein, “chemically bonded combinations thereof” means that adjacent groups, (β and γ groups) may form a chemical bond between them; in one embodiment, the β and γ groups are chemically bonded through one or more α groups there between.

[00237] As used herein, the terms “alkyleneamines”, “aryleneamines”, describe alkylamines and arylamines (respectively) that are deficient by two hydrogens, thus forming

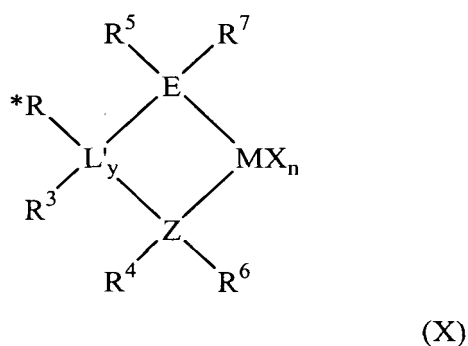
chemical bonds with two adjacent γ groups, or adjacent β and γ groups. Thus, an example of an alkyleneamine is $-\text{CH}_2\text{CH}_2\text{N}(\text{CH}_3)\text{CH}_2\text{CH}_2-$, and an example of a heterocyclic hydrocarbylene or aryleneamine is $-\text{C}_5\text{H}_3\text{N}-$ (divalent pyridine). An “alkylene-arylamine” is a group such as, for example, $-\text{CH}_2\text{CH}_2(\text{C}_5\text{H}_3\text{N})\text{CH}_2\text{CH}_2-$.

[00238] Described another way, the Group 15-containing catalyst component is represented by the structures (IX) and (X):

[00239]



[00240]



[00241] wherein E and Z are Group 15 elements independently selected from nitrogen and phosphorus in one embodiment; and nitrogen in a more particular embodiment;

[00242] L is selected from Group 15 atoms, Group 16 atoms, Group 15-containing hydrocarbylenes and a Group 16 containing hydrocarbylenes in one embodiment; wherein R^3 is absent when L is a Group 16 atom; in yet a more particular embodiment, when R^3 is

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

absent, L is selected from heterocyclic hydrocarbylenes; and in yet a more particular embodiment, L is selected from nitrogen, phosphorous, anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, indolylns; C₁ to C₆ alkyl substituted groups selected from anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, and indolylns; C₁ to C₆ alkylamine substituted groups selected from anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, and indolylns; amine substituted anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, and indolylns; hydroxy substituted groups selected from anilinylns, pyridyls, quinolylns, pyrrolylns, pyrimidyls, purinylns, imidazyls, and indolylns; methyl-substituted phenylamines, substituted derivatives thereof, and chemically bonded combinations thereof;

[00243] L' is selected from Group 15 atoms, Group 16 atoms, and Group 14 atoms in one embodiment; and selected from Group 15 and Group 16 atoms in a more particular embodiment; and is selected from groups as defined by L above in yet a more particular embodiment, wherein "EZL" and "EZL'" may be referred to as a "ligand", the EZL and EZL' ligands comprising the R* and R¹-R⁷ groups;

[00244] wherein L and L' may or may not form a bond with M;

[00245] y is an integer ranging from 0 to 2 (when y is 0, group L', *R and R³ are absent);

[00246] M is selected from Group 3 to Group 5 atoms, Group 4 atoms in a more particular embodiment, and selected from Zr and Hf in yet a more particular embodiment;

[00247] n is an integer ranging from 1 to 4 in one embodiment; n is an integer ranging from 2 to 3 in a more particular embodiment;

[00248] each X is as defined above;

[00249] R¹ and R² are independently: divalent bridging groups selected from alkylenes, arylenes, heteroatom containing alkylenes, heteroatom containing arylenes, substituted alkylenes, substituted arylenes and substituted heteroatom containing alkylenes, wherein the heteroatom is selected from silicon, oxygen, nitrogen, germanium, phosphorous, boron and sulfur in one embodiment; selected from C₁ to C₂₀ alkylenes, C₆ to C₁₂ arylenes, heteroatom-

containing C₁ to C₂₀ alkylenes and heteroatom-containing C₆ to C₁₂ arylenes in a more particular embodiment; and in yet a more particular embodiment selected from -CH₂-, -C(CH₃)₂-, -C(C₆H₅)₂-, -CH₂CH₂-, -CH₂CH₂CH₂-, -Si(CH₃)₂-, -Si(C₆H₅)₂-, -C₆H₁₀-, -C₆H₄-, and substituted derivatives thereof, the substitutions including C₁ to C₄ alkyls, phenyl, and halogen radicals;

[00250] R³ is absent in one embodiment; a group selected from hydrocarbyl groups, hydrogen radical, halogen radicals, and heteroatom-containing groups in a more particular embodiment; and selected from linear alkyls, cyclic alkyls, and branched alkyls having 1 to 20 carbon atoms in yet a more particular embodiment;

[00251] *R is absent in one embodiment; a group selected from hydrogen radical, Group 14 atom containing groups, halogen radicals, and a heteroatom-containing groups in yet a more particular embodiment;

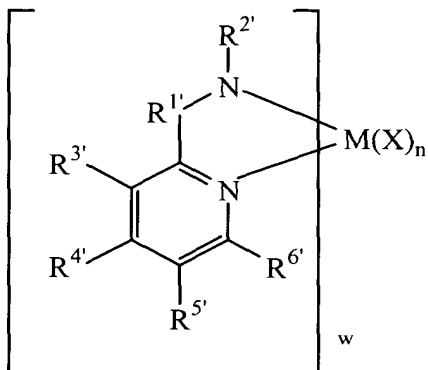
[00252] R⁴ and R⁵ are independently: groups selected from alkyls, aryls, substituted aryls, cyclic alkyls, substituted cyclic alkyls, cyclic arylalkyls, substituted cyclic arylalkyls and multiple ring systems in one embodiment, each group having up to 20 carbon atoms, and between 3 and 10 carbon atoms in a more particular embodiment; selected from C₁ to C₂₀ alkyls, C₁ to C₂₀ aryls, C₁ to C₂₀ arylalkyls, and heteroatom-containing groups (for example PR₃, where R is an alkyl group) in yet a more particular embodiment; and

[00253] R⁶ and R⁷ are independently: absent in one embodiment; groups selected from hydrogen radicals, halogen radicals, heteroatom-containing groups and hydrocarbyls in a more particular embodiment; selected from linear, cyclic and branched alkyls having from 1 to 20 carbon atoms in yet a more particular embodiment;

[00254] wherein R¹ and R² may be associated with one another, and/or R⁴ and R⁵ may be associated with one another as through a chemical bond.

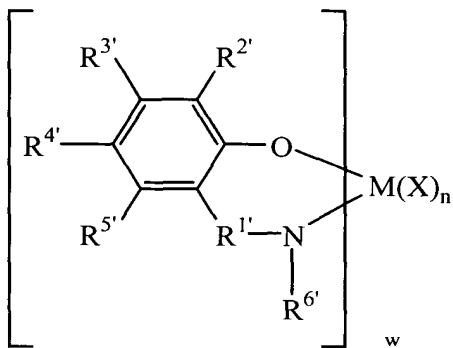
[00255] Described yet more particularly, the Group 15-containing catalyst component can be described as the embodiments shown in structures (XI), (XII) and (XIII) (where "N" is nitrogen):

[00256]



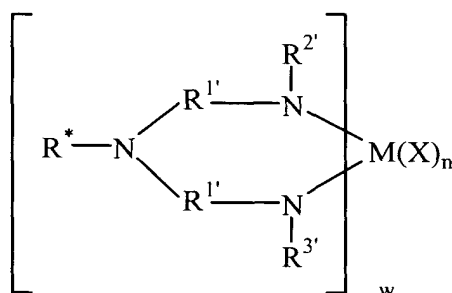
(XI)

[00257]



(XII)

[00258]



(XIII)

[00259] wherein structure (XI) represents pyridyl-amide structures, structure (XII) represents imino-phenol structures, and structure (XIII) represents bis(amide) structures; wherein w is an integer from 1 to 3, and 1 or 2 in a more particular embodiment, and 1 in yet a more particular embodiment; M is a Group 3 to Group 13 element, a Group 3 to Group 6 element in a more particular embodiment, and a Group 4 element in yet a more particular embodiment; each X is independently selected from hydrogen radicals, halogen ions (desirably, anions of fluorine, chlorine, and bromine); C₁ to C₆ alkyls; C₁ to C₆ fluoroalkyls, C₆ to C₁₂ aryls; C₆ to C₁₂ fluoroalkyls, C₁ to C₆ alkoxys, C₆ to C₁₂ aryloxys, and C₇ to C₁₈ alkylaryloxys; n is an integer ranging from 0 to 4, and from 1 to 3 in a more particular embodiment, and from 2 to 3 in yet a more particular embodiment, and 2 in yet a more particular embodiment;

[00260] and further, wherein in structures (XI), (XII), and (XIII), R^{1'} is selected from hydrocarbylenes and heteroatom-containing hydrocarbylenes in one embodiment, and selected from -SiR₂-, alkylenes, arylenes, alkenylenes and substituted alkylenes, substituted alkenylenes and substituted arylenes in another embodiment; and selected from -SiR₂-, C₁ to C₆ alkylenes, C₆ to C₁₂ arylenes, C₁ to C₆ substituted alkylenes and C₆ to C₁₂ substituted arylenes in another embodiment, wherein R is selected from C₁ to C₆ alkyls and C₆ to C₁₂ aryls; and

[00261] R^{2'}, R^{3'}, R^{4'}, R^{5'}, R^{6'} and R* are independently selected from hydride, C₁ to C₁₀ alkyls, C₆ to C₁₂ aryls, C₆ to C₁₈ alkylaryl, C₄ to C₁₂ heterocyclic hydrocarbyls, substituted C₁ to C₁₀ alkyls, substituted C₆ to C₁₂ aryls, substituted C₆ to C₁₈ alkylaryl, and substituted

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

C₄ to C₁₂ heterocyclic hydrocarbyls and chemically bonded combinations thereof in one embodiment; wherein R* is absent in a particular embodiment; and in another embodiment, R*-N represents a nitrogen containing group or ring such as a pyridyl group or a substituted pyridyl group that is bridged by the R^{1'} groups. In yet another embodiment, R*-N is absent, and the R^{1'} groups form a chemical bond to one another.

[00262] In one embodiment of structures (XI), (XII), and (XIII), R^{1'} is selected from methylene, ethylene, 1-propylene, 2-propylene, =Si(CH₃)₂, =Si(phenyl)₂, -CH=, -C(CH₃)=, -C(phenyl)₂-, -C(phenyl)= (wherein "=" represents two chemical bonds), and the like.

[00263] In a particular embodiment of structure (XII), R^{2'} and R^{4'} are selected from 2-methylphenyl, 2-n-propylphenyl, 2-iso-propylphenyl, 2-iso-butylphenyl, 2-tert-butylphenyl, 2-fluorophenyl, 2-chlorophenyl, 2-bromophenyl, 2-methyl-4-chlorophenyl, 2-n-propyl-4-chlorophenyl, 2-iso-propyl-4-chlorophenyl, 2-iso-butyl-4-chlorophenyl, 2-tert-butyl-4-chlorophenyl, 2-methyl-4-fluorophenyl, 2-n-propyl-4-fluorophenyl, 2-iso-propyl-4-fluorophenyl, 2-iso-butyl-4-fluorophenyl, 2-tert-butyl-4-fluorophenyl, 2-methyl-4-bromophenyl, 2-n-propyl-4-bromophenyl, 2-iso-propyl-4-bromophenyl, 2-iso-butyl-4-bromophenyl, 2-tert-butyl-4-bromophenyl, and the like.

[00264] In yet another particular embodiment of structures (XI) and (XIII), R^{2'} and R^{3'} are selected from 2-methylphenyl, 2-n-propylphenyl, 2-iso-propylphenyl, 2-iso-butylphenyl, 2-tert-butylphenyl, 2-fluorophenyl, 2-chlorophenyl, 2-bromophenyl, 4-methylphenyl, 4-n-propylphenyl, 4-iso-propylphenyl, 4-iso-butylphenyl, 4-tert-butylphenyl, 4-fluorophenyl, 4-chlorophenyl, 4-bromophenyl, 6-methylphenyl, 6-n-propylphenyl, 6-iso-propylphenyl, 6-iso-butylphenyl, 6-tert-butylphenyl, 6-fluorophenyl, 6-chlorophenyl, 6-bromophenyl, 2,6-dimethylphenyl, 2,6-di-n-propylphenyl, 2,6-di-iso-propylphenyl, 2,6-di-isobutylphenyl, 2,6-di-tert-butylphenyl, 2,6-difluorophenyl, 2,6-dichlorophenyl, 2,6-dibromophenyl, 2,4,6-trimethylphenyl, 2,4,6-tri-n-propylphenyl, 2,4,6-tri-iso-propylphenyl, 2,4,6-tri-iso-butylphenyl, 2,4,6-tri-tert-butylphenyl, 2,4,6-trifluorophenyl, 2,4,6-trichlorophenyl, 2,4,6-tribromophenyl, 2,3,4,5,6-pentafluorophenyl, 2,3,4,5,6-pentachlorophenyl, 2,3,4,5,6-pentabromophenyl, and the like.

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Attorney Docket No.: 2001-017 (UNIV/0017)

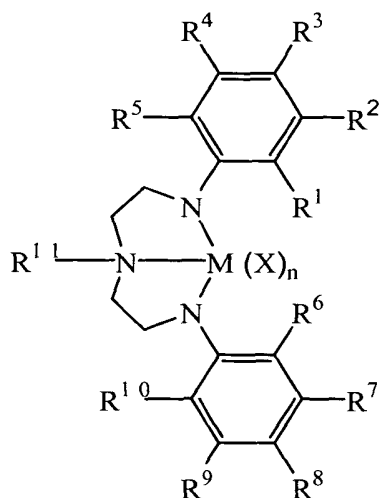
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[00265] In another embodiment of structures (XI), (XII), and (XIII), X is independently selected from fluoride, chloride, bromide, methyl, ethyl, phenyl, benzyl, phenyloxy, benzloxy, 2-phenyl-2-propoxy, 1-phenyl-2-propoxy, 1-phenyl-2-butoxy, 2-phenyl-2-butoxy and the like.

[00266] As used herein, “chemically bonded combinations” means that adjacent groups may form a chemical bond between them, thus forming a ring system, either saturated, partially unsaturated, or aromatic.

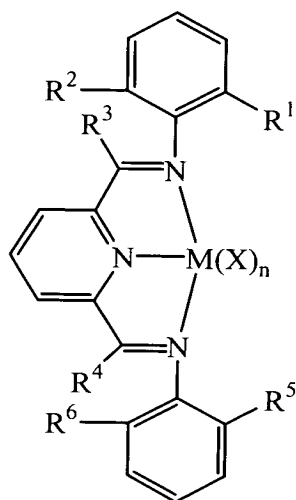
[00267] Non-limiting examples of the Group 15-containing catalyst component are represented by the structures (XIVa) - (XIVf) (where “N” is nitrogen):

[00268]

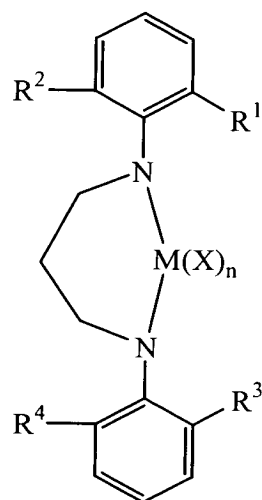


(XIVa)

[00269]

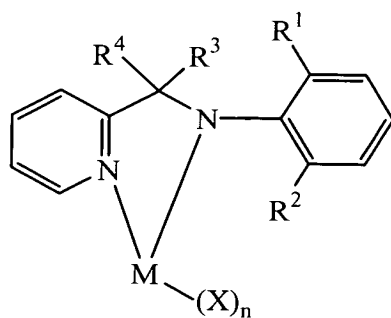


(XIVb)



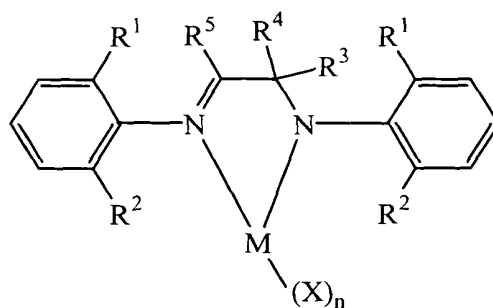
(XIVc)

[00270]



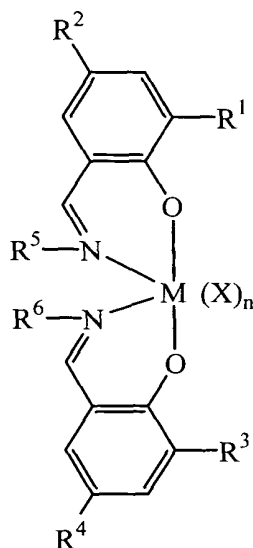
(XIVd)

[00271]



(XIVe)

[00272]



(XIVf)

[00273] wherein in structures (XIVa) through (XIVf) M is selected from Group 4 atoms in one embodiment; and M is selected from Zr and Hf in a more particular embodiment; and wherein R¹ through R¹¹ in structures (XIVa) through (XIVf) are selected from hydride, fluorine radical, chlorine radical, bromine radical, methyl, ethyl, n-propyl, isopropyl, n-butyl, isobutyl, tert-butyl and phenyl; and X is selected from fluorine ion, chlorine ion, bromine ion, methyl, phenyl, benzyl, phenyloxy and benzyloxy; and n is an integer ranging from 0 to 4, and from 2 to 3 in a more particular embodiment.

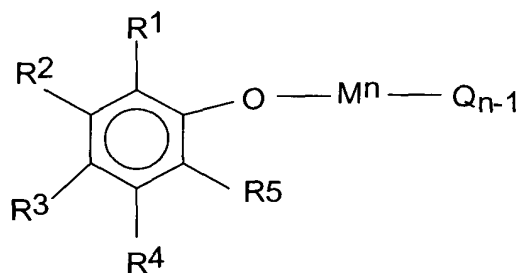
[00274] The Group 15-containing catalyst components are prepared by methods known in the art, such as those disclosed in, for example, EP 0 893 454 A1, US 5,889,128, US 6,333,389 B2 and WO 00/37511.

[00275] The "Group 15-containing catalyst component" may comprise any combination of any "embodiment" described herein.

Phenoxide Transition Metal Catalyst Compositions

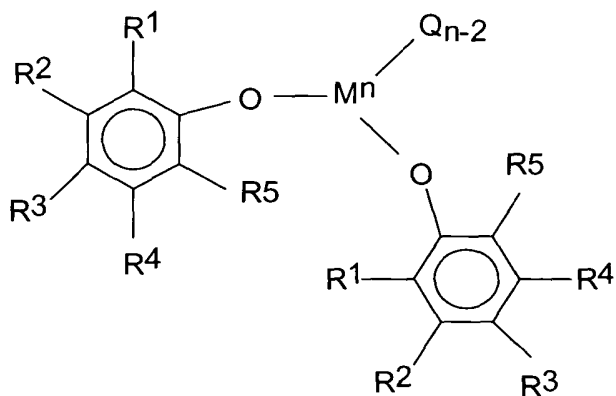
[00276] Phenoxide transition metal catalyst compositions are heteroatom substituted phenoxide ligated Group 3 to 10 transition metal or lanthanide metal compounds wherein the metal is bound to the oxygen of the phenoxide group. Phenoxide transition metal catalyst compounds may be represented by Formula XV or XVI:

[00277]



(XV)

[00278] or



(XVI)

[00279] wherein R^1 is hydrogen or a C_4 to C_{100} group, preferably a tertiary alkyl group, preferably a C_4 to C_{20} alkyl group, preferably a C_4 to C_{20} tertiary alkyl group, preferably a neutral C_4 to C_{100} group and may or may not also be bound to M;

[00280] at least one of R^2 to R^5 is a heteroatom containing group, the rest of R^2 to R^5 are independently hydrogen or a C_1 to C_{100} group, preferably a C_4 to C_{20} alkyl group, preferred examples of which include butyl, isobutyl, t-butyl, pentyl, hexyl, heptyl, isohexyl, octyl, isooctyl, decyl, nonyl, dodecyl, and any of R^2 to R^5 also may or may not be bound to M;

[00281] Each R^1 to R^5 group may be independently substituted or unsubstituted with other atoms, including heteroatoms or heteroatom containing group(s);

[00282] O is oxygen;

[00283] M is a Group 3 to Group 10 transition metal or lanthanide metal, preferably a Group 4 metal, preferably M is Ti, Zr or Hf;

[00284] n is the valence state of the metal M, preferably 2, 3, 4, or 5; and

[00285] Q is, and each Q may be independently be, an alkyl, halogen, benzyl, amide, carboxylate, carbamate, thiolate, hydride or alkoxide group, or a bond to an R group containing a heteroatom which may be any of R¹ to R⁵.

[00286] A heteroatom containing group may be any heteroatom or a heteroatom bound to carbon, silicon or another heteroatom. Preferred heteroatoms include boron, aluminum, silicon, nitrogen, phosphorus, arsenic, tin, lead, antimony, oxygen, selenium, and tellurium. Particularly preferred heteroatoms include nitrogen, oxygen, phosphorus, and sulfur. Even more particularly preferred heteroatoms include nitrogen and oxygen. The heteroatom itself may be directly bound to the phenoxide ring or it may be bound to another atom or atoms that are bound to the phenoxide ring. The heteroatom containing group may contain one or more of the same or different heteroatoms. Preferred heteroatom containing groups include imines, amines, oxides, phosphines, ethers, ketones, oxoazolines heterocyclics, oxazolines, thioethers, and the like. Particularly preferred heteroatom containing groups include imines. Any two adjacent R groups may form a ring structure, preferably a 5 or 6 membered ring. Likewise the R groups may form multi-ring structures. In one embodiment any two or more R groups do not form a 5 membered ring.

[00287] In a preferred embodiment the heteroatom substituted phenoxide transition metal compound is an iminophenoxide Group 4 transition metal compound, and more preferably an iminophenoxidezirconium compound.

Supported Catalyst Systems

[00288] The term "supported" as used herein refers to one or more compounds that are deposited on, contacted with, vaporized with, bonded to, or incorporated within, adsorbed or absorbed in, or on, a support or carrier. The terms "support" or "carrier" for purposes of this specification are used interchangeably and are any support material, preferably a porous support material, including inorganic or organic support materials. Non-limiting examples of inorganic support materials include inorganic oxides and inorganic chlorides. Other carriers include resinous support materials such as polystyrene, functionalized or crosslinked organic supports, such as polystyrene, divinyl benzene, polyolefins, or polymeric compounds,

zeolites, talc, clays, or any other organic or inorganic support material and the like, or mixtures thereof.

[00289] The support materials utilized may be any of the conventional support materials. Preferably the supported material is a porous support material, for example, talc, inorganic oxides and inorganic chlorides. Other support materials include resinous support materials such as polystyrene, functionalized or crosslinked organic supports, such as polystyrene divinyl benzene polyolefins or polymeric compounds, zeolites, clays, or any other organic or inorganic support material and the like, or mixtures thereof.

[00290] The preferred support materials are inorganic oxides that include those Group 2, 3, 4, 5, 13 or 14 metal oxides. The preferred supports include silica, fumed silica, alumina, silica-alumina and mixtures thereof. Other useful supports include magnesia, titania, zirconia, magnesium chloride, montmorillonite, phyllosilicate, zeolites, talc, clays and the like. Also, combinations of these support materials may be used, for example, silica-chromium, silica-alumina, silica-titania and the like. Additional support materials may include those porous acrylic polymers. Other support materials include nanocomposites, aerogels, spherulites, and polymeric beads. Another support is fumed silica available under the trade name Cabosil™ TS-610, available from Cabot Corporation. Fumed silica is typically a silica with particles 7 to 30 nanometers in size that has been treated with dimethylsilyldichloride such that a majority of the surface hydroxyl groups are capped.

[00291] In another embodiment, any of the conventionally known inorganic oxides, such as silica, support materials that retain hydroxyl groups after dehydration treatment methods will be suitable in accordance with the invention. Because of availability, both of silica and silica containing metal oxide based supports, for example, silica-alumina, are preferred. Silica particles, gels and glass beads are most typical.

[00292] These metal oxide compositions may additionally contain oxides of other metals, such as those of Al, K, Mg, Na, Si, Ti and Zr and should preferably be treated by thermal and/or chemical means to remove water and free oxygen. Typically such treatment is in a vacuum in a heated oven, in a heated fluidized bed or with dehydrating agents such as organo silanes, siloxanes, alkyl aluminum compounds, etc. The level of treatment should be such

that as much retained moisture and oxygen as is possible is removed, but that a chemically significant amount of hydroxyl functionality is retained. Thus calcining at up to 800 °C or more up to a point prior to decomposition of the support material, for several hours is permissible, and if higher loading of supported anionic activator is desired, lower calcining temperatures for lesser times will be suitable. Where the metal oxide is silica, loadings to achieve from less than 0.1 mmol to 3.0 mmol activator/g SiO₂ are typically suitable and can be achieved, for example, by varying the temperature of calcining from 200°C to 1,000 °C, such as from 300°C to 900°C, 400°C to 875°C, 500°C to 850°C, 600°C to 825°C, 700°C to 800°C, and any combination of any limit with any lower limit.

[00293] The tailoring of hydroxyl groups available as attachment sites in this invention can also be accomplished by the pre-treatment with a less than stoichiometric amount of a chemical dehydrating agent. If calcining temperatures below 400°C are employed, difunctional coupling agents (e.g., (CH₃)₃SiCl₂) may be employed to cap hydrogen bonded pairs of silanol groups which are present under the less severe calcining conditions. Similarly, use of the Lewis acid in excess of the stoichiometric amount needed for reaction with the transition metal compounds will serve to neutralize excess silanol groups without significant detrimental effect for catalyst preparation or subsequent polymerization.

[00294] In another embodiment, the support is a polymeric support, including hydroxyl-functional-group-containing polymeric substrates, but functional groups may be any of the primary alkyl amines, secondary alkyl amines, and others, where the groups are structurally incorporated in a polymeric chain and capable of an acid-base reaction with the Lewis acid such that a ligand filling one coordination site of the aluminum is protonated and replaced by the polymer incorporated functionality. See, for example, the functional group containing polymers of U.S. Patent No. 5,288,677.

[00295] It is preferred that the support material, most preferably an inorganic oxide, has a surface area in the range of from about 10 to about 700 m²/g, pore volume in the range of from about 0.1 to about 4.0 cc/g and average particle size in the range of from about 5 to about 500 µm. More preferably, the surface area of the support material is in the range of from about 50 to about 500 m²/g, pore volume of from about 0.5 to about 3.5 cc/g and

average particle size of from about 10 to about 200 μm . The average pore size of the carrier is typically in the range of from 10 to 1000 \AA , preferably 50 to about 500 \AA , and most preferably 75 to about 350 \AA .

[00296] The support materials may be treated chemically, for example with a fluoride compound as described in WO 00/12565. Other supported activators are described in for example WO 00/13792 that refers to supported boron containing solid acid complex.

[00297] In one aspect, the active polymerization catalyst system is formed by contacting a catalyst support with the one or more dialuminoxanes to form a treated catalyst support. The treated catalyst support is then contacted with the one or more halogen substituted aryl boranes to form a supported activator. The supported activator is then contacted with the one or more polymerization catalysts to form the supported polymerization catalyst system.

[00298] In one embodiment, the support material having the dialuminoxane compound bonded thereto may be prepared by combining the dialuminoxane with the support material in a suitable solvent. In one embodiment, the combination is carried out at any suitable pressure and temperature under an inert atmosphere. Preferably the combination is at atmospheric pressure, ambient temperature under nitrogen. More preferably, the mixture is heated to less than about 200°C, more preferably less than 150°C. The dialuminoxane is contacted with the support for a suitable amount of time, such as about 1 minute, preferably about 1 minute to about 10 hours, more preferably for about 1 minute to about 3 hours prior to the addition of the one or more halogen substituted aryl boranes.

[00299] In another embodiment, an antistatic agent or surface modifier that is used in the preparation of the supported catalyst system as described in PCT publication WO 96/11960 may be used with catalyst systems including the activator compounds described herein. The catalyst systems may also be prepared in the presence of an olefin, for example 1-hexene.

[00300] In another embodiment, the activator and/or catalyst system may be combined with a carboxylic acid salt of a metal ester, for example aluminum carboxylates such as aluminum mono, di- and tri- stearates, aluminum octoates, oleates and cyclohexylbutyrates, as described in U.S. Patents 6,300,436 and 6,306,984.

Polymerization Process

[00301] The activators and the polymerization catalysts described above, whether supported or not, are suitable for use in any prepolymerization and/or polymerization process over a wide range of temperatures and pressures. The temperatures may be in the range of from -60°C to about 280°C , preferably from 50°C to about 200°C . In one embodiment, the polymerization temperature is above 0°C , above 50°C , above 80°C , above 100°C , above 150°C , or above 200°C . In one embodiment, the pressures employed may be in the range from 1 atmosphere to about 500 atmospheres or higher.

[00302] Polymerization processes include solution, gas phase, slurry phase, and a high pressure process, or a combination thereof. Particularly preferred is a gas phase or slurry phase polymerization of one or more olefin(s) at least one of which is ethylene or propylene.

[00303] In one embodiment, the process is a solution, high pressure, slurry or gas phase polymerization process of one or more olefin monomers having from 2 to 30 carbon atoms, preferably 2 to 12 carbon atoms, and more preferably 2 to 8 carbon atoms. The invention is particularly well suited to the polymerization of two or more olefin monomers of ethylene, propylene, 1-butene, 1-pentene, 4-methyl-1-pentene, 1-hexene, 1-octene and 1-decene.

[00304] Other monomers useful include ethylenically unsaturated monomers, diolefins having 4 to 18 carbon atoms, conjugated or nonconjugated dienes, polyenes, vinyl monomers and cyclic olefins. Non-limiting monomers useful in the invention may include norbornene, norbornadiene, isobutylene, isoprene, vinylbenzocyclobutane, styrenes, alkyl substituted styrene, ethylidene norbornene, dicyclopentadiene and cyclopentene.

[00305] In another embodiment, a copolymer of ethylene is produced, where with ethylene, a comonomer having at least one alpha-olefin having from 4 to 15 carbon atoms, preferably from 4 to 12 carbon atoms, and most preferably from 4 to 8 carbon atoms, is polymerized in a gas phase process.

[00306] In another embodiment, ethylene or propylene is polymerized with at least two different comonomers, optionally one of which may be a diene, to form a terpolymer.

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

[00307] In one embodiment, the invention is directed to a polymerization process, particularly a gas phase or slurry phase process, for polymerizing propylene alone or with one or more other monomers including ethylene, and/or other olefins having from 4 to 12 carbon atoms.

[00308] Typically in a gas phase polymerization process, a continuous cycle is employed where in one part of the cycle of a reactor system, a cycling gas stream, otherwise known as a recycle stream or fluidizing medium, is heated in the reactor by the heat of polymerization. This heat is removed from the recycle composition in another part of the cycle by a cooling system external to the reactor. Generally, in a gas fluidized bed process for producing polymers, a gaseous stream containing one or more monomers is continuously cycled through a fluidized bed in the presence of a catalyst under reactive conditions. The gaseous stream is withdrawn from the fluidized bed and recycled back into the reactor. Simultaneously, polymer product is withdrawn from the reactor and fresh monomer is added to replace the polymerized monomer.

[00309] The reactor pressure in a gas phase process may vary from about 100 psig (690 kPa) to about 500 psig (3448 kPa), preferably in the range of from about 200 psig (1379 kPa) to about 400 psig (2759 kPa), more preferably in the range of from about 250 psig (1724 kPa) to about 350 psig (2414 kPa).

[00310] The reactor temperature in a gas phase process may vary from about 30°C to about 120°C, preferably from about 60°C to about 115°C, more preferably in the range of from about 70°C to 110°C, and most preferably in the range of from about 70°C to about 95°C. In another embodiment, the reactor temperature in a gas phase process is above 60°C.

[00311] Other gas phase processes include series or multistage polymerization processes. Gas phase processes may also include those described in U.S. Patent Nos. 5,627,242, 5,665,818 and 5,677,375, and European publications EP-A- 0 794 200 EP-B1-0 649 992, EP-A- 0 802 202 and EP-B- 634 421.

[00312] In another embodiment, the process may produce greater than 500 lbs of polymer per hour (227 Kg/hr) to about 200,000 lbs/hr (90,900 Kg/hr) or higher of polymer, preferably

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

greater than 1000 lbs/hr (455 Kg/hr), more preferably greater than 10,000 lbs/hr (4540 Kg/hr), even more preferably greater than 25,000 lbs/hr (11,300 Kg/hr), still more preferably greater than 35,000 lbs/hr (15,900 Kg/hr), still even more preferably greater than 50,000 lbs/hr (22,700 Kg/hr) and most preferably greater than 65,000 lbs/hr (29,000 Kg/hr) to greater than 100,000 lbs/hr (45,500 Kg/hr).

[00313] A slurry polymerization process generally uses pressures in the range of from about 1 to about 50 atmospheres and even greater and temperatures in the range of 0°C to about 120°C. In another embodiment, the slurry process temperature is above 100°C. In a slurry polymerization, a suspension of solid, particulate polymer is formed in a liquid polymerization diluent medium to which ethylene and comonomers and often hydrogen along with catalyst are added. The suspension including diluent is intermittently or continuously removed from the reactor where the volatile components are separated from the polymer and recycled, optionally after a distillation, to the reactor. The liquid diluent employed in the polymerization medium is typically an alkane having from 3 to 7 carbon atoms, preferably a branched alkane. The medium employed should be liquid under the conditions of polymerization and relatively inert. When a propane medium is used the process must be operated above the reaction diluent critical temperature and pressure. Preferably, a hexane or an isobutane medium is employed.

[00314] In another embodiment, the polymerization technique is referred to as a particle form polymerization, or a slurry process where the temperature is kept below the temperature at which the polymer goes into solution. Such technique is well known in the art, and described in for instance U.S. Patent No. 3,248,179. Other slurry processes include those employing a loop reactor and those utilizing a plurality of stirred reactors in series, parallel, or combinations thereof. Non-limiting examples of slurry processes include continuous loop or stirred tank processes. Also, other examples of slurry processes are described in U.S. Patent No. 4,613,484,.

[00315] In another embodiment, this process may produce greater than 2000 lbs of polymer per hour (907 Kg/hr), more preferably greater than 5000 lbs/hr (2268 Kg/hr), and most preferably greater than 10,000 lbs/hr (4540 Kg/hr). In another embodiment the slurry

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

reactor may produce greater than 15,000 lbs of polymer per hour (6804 Kg/hr), preferably greater than 25,000 lbs/hr (11,340 Kg/hr) to about 100,000 lbs/hr (45,500 Kg/hr).

[00316] Examples of solution processes are described in U.S. Patent Nos. 4,271,060, 5,001,205, 5,236,998 and 5,589,555 and PCT WO 99/32525.

[00317] In one embodiment, the slurry or gas phase process is operated in the presence of the catalyst system described herein and in the absence of or essentially free of any scavengers, such as triethylaluminum, trimethylaluminum, tri-isobutylaluminum and tri-n-hexylaluminum and diethyl aluminum chloride, dibutyl zinc and the like. This process is described in PCT publication WO 96/08520 and U.S. Patent No. 5,712,352 and 5,763,543.

[00318] In another embodiment, the method provides for injecting the catalyst system described herein into a reactor, particularly a gas phase reactor. In one embodiment the catalyst system is used in the unsupported form, preferably in a liquid form such as described in U.S. Patent Nos. 5,317,036 and 5,693,727 and European publication EP-A-0 593 083. The polymerization catalyst in liquid form can be fed with an activator, and/or a support, and/or a supported activator together or separately to a reactor. The injection methods described in PCT publication WO 97/46599 may be utilized.

[00319] Where an unsupported catalyst system is used the mole ratio of the metal of the activator component to the metal of the catalyst compound is in the range of between 0.3:1 to 10,000:1, preferably 100:1 to 5000:1, and most preferably 500:1 to 2000:1.

Polymer Products

[00320] The polymers produced can be used in a wide variety of products and end-use applications. The polymers produced include polyethylene homopolymers and polyethylene co-polymers, including linear low density polyethylene, elastomers, plastomers, high density polyethylenes, medium density polyethylenes, low density polyethylenes, as well as polypropylene homopolymers and polypropylene co polymers.

[00321] The polymers, typically ethylene based polymers, have a density in the range of from 0.86g/cc to 0.97 g/cc, preferably in the range of from 0.88 g/cc to 0.965 g/cc, more preferably in the range of from 0.900 g/cc to 0.96 g/cc, even more preferably in the range of

from 0.905 g/cc to 0.95 g/cc, yet even more preferably in the range from 0.910 g/cc to 0.940 g/cc, and most preferably greater than 0.915 g/cc, preferably greater than 0.920 g/cc, and most preferably greater than 0.925 g/cc. Density is measured in accordance with ASTM-D-1238.

[00322] The polymers produced typically have a molecular weight distribution, a weight average molecular weight to number average molecular weight (M_w/M_n) of greater than 1.5 to about 15, particularly greater than 2 to about 10, more preferably greater than about 2.2 to less than about 8, and most preferably from 2.5 to 8. The polymers may have a narrow molecular weight distribution and a broad composition distribution or vice-versa, and may be those polymers described in U.S. Patent No. 5,798,427.

[00323] Also, the polymers typically have a narrow composition distribution as measured by Composition Distribution Breadth Index (CDBI). Further details of determining the CDBI of a copolymer are known to those skilled in the art. See, for example, PCT Patent Application WO 93/03093, published February 18, 1993. The polymers in one embodiment have CDBI's generally in the range of greater than 50% to 100%, preferably 99%, preferably in the range of 55% to 85%, and more preferably 60% to 80%, even more preferably greater than 60%, still even more preferably greater than 65%. In another embodiment, polymers produced using a catalyst system described herein have a CDBI less than 50%, more preferably less than 40%, and most preferably less than 30%.

[00324] The polymers in one embodiment have a melt index (MI) or (I_2) as measured by ASTM-D-1238-E (190/2.16) in the range from no measurable flow to 1000 dg/min, more preferably from about 0.01 dg/min to about 100 dg/min, even more preferably from about 0.1 dg/min to about 50 dg/min, and most preferably from about 0.1 dg/min to about 10 dg/min.

[00325] In one embodiment, the polymers have a melt index ratio (I_{21}/I_2) (I_{21} is measured by ASTM-D-1238-F) (190/21.6) of from 10 to less than 25, more preferably from about 15 to less than 25. The polymers, in a preferred embodiment, have a melt index ratio (I_{21}/I_2) of from greater than 25, more preferably greater than 30, even more preferably greater than 40, still even more preferably greater than 50 and most preferably greater than 65. For example,

the melt index ratio (I_{21}/I_2) may be of from 5 to 300, 10 to 200, 20 to 180, 30 to 160, 40 to 120, 50 to 100, 60 to 90, and a combination of any upper limit with any lower limit.

[00326] In yet another embodiment, propylene based polymers are produced. These polymers include atactic polypropylene, isotactic polypropylene, hemi-isotactic and syndiotactic polypropylene. Other propylene polymers include propylene block or impact copolymers. Propylene polymers of these types are well known in the art see for example U.S. Patent Nos. 4,794,096, 3,248,455, 4,376,851, 5,036,034 and 5,459,117.

[00327] The polymers may be blended and/or coextruded with any other polymer. Non-limiting examples of other polymers include linear low density polyethylenes, elastomers, plastomers, high pressure low density polyethylene, high density polyethylenes, polypropylenes and the like.

[00328] The polymers produced and blends thereof are useful in such forming operations as film, sheet, and fiber extrusion and co-extrusion as well as blow molding, injection molding and rotary molding. Films include blown or cast films formed by coextrusion or by lamination useful as shrink film, cling film, stretch film, sealing films, oriented films, snack packaging, heavy duty bags, grocery sacks, baked and frozen food packaging, medical packaging, industrial liners, membranes, etc. in food-contact and non-food contact applications. Fibers include melt spinning, solution spinning and melt blown fiber operations for use in woven or non-woven form to make filters, diaper fabrics, medical garments, geotextiles, etc. Extruded articles include medical tubing, wire and cable coatings, pipe, geomembranes, and pond liners. Molded articles include single and multi-layered constructions in the form of bottles, tanks, large hollow articles, rigid food containers and toys, etc.

EXAMPLES

[00329] In order to provide a better understanding of the foregoing discussion, the following non-limiting examples are offered. Although the examples may be directed to specific embodiments of the present invention, they are not to be viewed as limiting the invention in any specific respect. All parts, proportions, and percentages are by weight unless otherwise indicated. All examples were carried out in dry, oxygen-free environments

and solvents. All molecular weights are weight average molecular weight unless otherwise noted. Molecular weights (weight average molecular weight (M_w) and number average molecular weight (M_n) and (M_z) were measured by Gel Permeation Chromatography (GPC).

CATALYST PREPARATION

[00330] The catalyst synthesis and preparation is described below. In each of the examples to follow, tris(perfluorophenyl)borane was purchased from Boulder Chemical Co., located in Boulder, Colorado, and used as received. Tetraethyldialuminoxane (1.0 molar in toluene) and all solvents were purchased from Aldrich and used as received. Bis(1,3-methyl, n-butyl cyclopentadienyl) zirconium dimethyl ($((1,3\text{-MeBuCp})_2\text{ZrMe}_2)$ solution (20 wt% in toluene) was purchased from Norquay Single-Site Catalysts and used as received. The silica was Grace Davison 948 and calcined to the appropriate temperature described below.

[00331] The $(-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2)$ catalyst was a reaction product of one equivalent of $(-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrCl}_2)$ and two equivalents of methyl lithium in diethyl ether. The $(-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrCl}_2)$ was synthesized as described in U.S. Patent No. 6,339,134, and the methyl lithium was purchased from Aldrich and used as received.

EXAMPLE 1

[00332] 0.860 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.05 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $(-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2)$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 2

[00333] 0.645 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.05 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 3

[00334] 0.430 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.05 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 4

[00335] 0.650 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.075 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams

of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 5

[00336] 0.650 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.10 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 6

[00337] 0.650 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.15 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 7

[00338] 1.07 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 400°C) in a 100 mL flask. The resulting slurry was allowed to sit

PATENT

Attorney Docket No.: 2001-017 (UNIV/0017)

Express Mail No.: EV 349850690 US

overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.10 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 8

[00339] 0.860 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 400°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.10 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 9

[00340] 0.645 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 400°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.10 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 10

[00341] 0.860 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 400°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.125 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 11

[00342] 0.860 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 400°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.15 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 12

[00343] 0.860 grams of tetraethyldialuminoxane was combined with 1.0 grams of silica (Davison 948 calcined at 400°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.20 grams of tris(perfluorophenyl)borane was added to the dialuminoxane treated silica, slurried in toluene and heated to 100°C for three hours. The silica was then filtered,

rinsed with several 10 mL portions of toluene, and subsequently combined with 0.025 grams of $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 13

[00344] In a 100 mL round bottom flask, 860 mg of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 400°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 200 mg of trisperfluorophenylborane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was removed from the oil bath and allowed to cool to room temperature. The slurry was then filtered, washed with toluene, and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of $(1,3\text{-MeBuCp})_2\text{ZrMe}_2$ solution was dissolved in 30 mL of toluene. The partially dried activator treated silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 14

[00345] In a 100 mL round bottom flask, 860 mg of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 300°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of trisperfluorophenylborane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was removed from the oil bath and allowed to cool to room temperature. The slurry was then

filtered, washed with toluene, and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of (1,3-MeBuCp)₂ZrMe₂ solution was dissolved in 30 mL of toluene. The partially dried silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 15

[00346] In a 100 mL round bottom flask, 930 mg of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 300°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 200 mg of tris(perfluorophenyl)borane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was removed from the oil bath and allowed to cool to room temperature. The slurry was then filtered, washed with toluene and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of (1,3-MeBuCp)₂ZrMe₂ solution was dissolved in 30 mL of toluene. The partially dried silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 16

[00347] In a 100 mL round bottom flask, 1.00 g of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 300°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 250 mg of tris(perfluorophenyl)borane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was

removed from the oil bath and allowed to cool to room temperature. The slurry was then filtered, washed with toluene and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of (1,3-MeBuCp)₂ZrMe₂ solution was dissolved in 30 mL of toluene. The partially dried silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 17

[00348] In a 100 mL round bottom flask, 1.00 g of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 200°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of tris(perfluorophenyl)borane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was removed from the oil bath and allowed to cool to room temperature. The slurry was then filtered, washed with toluene and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of (1,3-MeBuCp)₂ZrMe₂ solution was dissolved in 30 mL of toluene. The partially dried silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 18

[00349] In a 100 mL round bottom flask, 1.00 g of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 200°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 200 mg of tris(perfluorophenyl)borane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask

was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was removed from the oil bath and allowed to cool to room temperature. The slurry was then filtered, washed with toluene and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of (1,3-MeBuCp)₂ZrMe₂ solution was dissolved in 30 mL of toluene. The partially dried silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 19

[00350] In a 100 mL round bottom flask, 1.00 g of tetraethylaluminumoxane was dissolved in 30 mL of toluene. To this solution, 1.00 g. of silica (Davison 948 calcined at 200°C) was added. This slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit, washed with toluene (3 x 10 mL) and partially dried under vacuum. In a dry 100 mL round bottom flask, 250 mg of tris(perfluorophenyl)borane was dissolved in 30 mL of toluene. The partially dried silica was transferred to the flask and slurried. The flask was placed in an oil bath at 100°C for three hours and stirred every half-hour. The flask was removed from the oil bath and allowed to cool to room temperature. The slurry was then filtered, washed with toluene and partially dried under vacuum. In a dry 100 mL round bottom flask, 100 mg of (1,3-MeBuCp)₂ZrMe₂ solution was dissolved in 30 mL of toluene. The partially dried silica was transferred into the flask and the slurry was allowed to stand overnight at room temperature. The slurry was filtered through a frit and dried thoroughly under vacuum.

EXAMPLE 20

[00351] 1.0 grams of tetraethylaluminumoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 300°C) in a 100 flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.10 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL

portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 21

[00352] 1.0 grams of tetraethyldialuminoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 300°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.20 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 22

[00353] 0.860 grams of tetraethyldialuminoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.10 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 23

[00354] 0.860 grams of tetraethyldialuminoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 200°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.25 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 24

[00355] 1.41 grams of tetraethyldialuminoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 200°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.20 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 25

[00356] 2.0 grams of tetraethyldialuminoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 200°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.1 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂

solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 26

[00357] 0.702 grams of tetraethyldialuminoxane in toluene was combined with 1.0 grams of silica (Davison 948 calcined at 200°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.1 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 140°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum.

EXAMPLE 27

[00358] 27.52 grams of tetraethyldialuminoxane in toluene was combined with 40.0 grams of silica (Davison 948 calcined at 200°C) in a 100 mL flask. The slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 50 mL portions of toluene. 4.0 grams of tris(perfluorophenyl)borane was added to silica, slurried in o-xylene and heated to 140°C for one hour. The temperature was reduced to 110°C, and the slurry was further heated for two hours. The silica was then filtered, rinsed with several 50 mL portions of toluene. The "activated" silica was then dried under vacuum. 34.6 grams of the product was combined with 2.63 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was then filtered, rinsed with several 50 mL portions of toluene, and dried under a vacuum.

Polymerizations:

[00359] Polymerizations were performed in a glass-lined 20 mL autoclave reactor equipped with a mechanical stirrer, an external heater for temperature control, a septum inlet and a regulated supply of dry nitrogen and ethylene in an inert atmosphere (nitrogen) glove box. The reactor was dried and degassed thoroughly at 115°C. At room temperature and atmospheric pressure, the reactor was charged with approximately 3,000 mg hexane, 17.0 mg hexene, and 1.5 mg tri-n-octylaluminum. The reactor was then charged with ethylene while stirring at 800 RPM and brought to a process pressure of 130 psig (896 kPa) and process temperature of 85°C. The supported catalyst was slurried and added via syringe with the reactor. The polymerization was continued while maintaining the reaction vessel within 3°C of the target process temperature (85°C) and within 5 psig (34 kPa) of the target process pressure (130 psig or 896 kPa). The typical reaction time was about 40 minutes. After about 40 minutes, the reaction was stopped by pressurizing the reactor to 30 psig (207 kPa) above the target process pressure with a gas mixture composed of 5 mol% oxygen in argon. The polymer was recovered by vacuum centrifugation of the reaction mixture. Bulk polymerization activity was calculated by dividing the yield of polymer by the total weight of the catalyst charge by the time in hours.

[00360] Polymerization results are shown below in Tables 1-3. Table 1 summarizes the results for Examples 1-12. Table 2 summarizes the results for Examples 13-19. Table 3 summarizes the results for Examples 20-27.

Table 1. Polymerizations via $-(\text{CH}_2)_4\text{-Si}(\text{CpMe}_4)(\text{Ind})\text{ZrMe}_2$

		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
EX. 1	1	2.40	223766	92186	2.40	0.018	53.3
	2	2.30	229367	110477	2.10	0.020	59.2
	3	2.50	231717	113054	2.00	0.023	68.1
	4	2.50	230625	110852	2.10	0.023	68.1
	5	2.40	225705	91848	2.50	0.023	68.1
	6	2.50	231697	101952	2.30	0.017	50.4
	average	2.43	228813	103395	2.23	0.021	61.2

PATENT
Attorney Docket No.: 2001-017 (UNIV/0017)
Express Mail No.: EV 349850690 US

		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
EX. 2	1	2.50	216081	102124	2.10	0.026	77.0
	2	2.50	230372	109867	2.10	0.042	124.4
	3	2.40	226393	90520	2.50	0.035	103.7
	4	2.50	231879	111562	2.10	0.029	85.9
	5	2.50	261782	75606	3.50	0.037	109.6
	6	2.40	234310	101197	2.30	0.030	88.9
	average	2.47	233470	98479	2.43	0.033	98.3
EX. 3	1	—	—	—	—	0.004	11.8
	2	—	—	—	—	0.004	11.8
	3	—	—	—	—	0.005	14.8
	4	—	—	—	—	0.004	11.8
	5	—	—	—	—	0.005	14.8
	6	—	—	—	—	0.005	14.8
	average	—	—	—	—	0.005	13.3
EX. 4	1	2.40	225368	110639	2.00	0.097	287.3
	2	2.60	230385	85842	2.70	0.090	266.5
	3	2.50	225504	85413	2.60	0.084	248.7
	4	2.50	236960	113359	2.10	0.082	242.8
	5	2.50	225313	104276	2.20	0.091	269.5
	6	2.50	228706	99906	2.32	0.089	263.0
	average	2.40	225368	110639	2.00	0.097	287.3
EX. 5	1	4.80	208283	78766	2.60	0.115	340.7
	2	2.70	233334	108107	2.20	0.081	383.4
	3	2.70	222881	106346	2.10	0.097	366.9
	4	2.80	218560	69140	3.20	0.101	299.1
	5	2.50	225332	109794	2.10	0.130	385.0
	6	2.50	222868	103050	2.20	0.113	382.1
	average	3.00	221876	95867	2.40	0.106	359.5
EX. 6	1	2.50	246777	97622	2.50	0.064	189.6
	2	2.80	235464	104411	2.30	0.060	177.7

		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
	3	3.00	239388	103743	2.30	0.056	165.9
	4	2.50	235636	95988	2.50	0.058	171.8
	5	2.60	237700	103687	2.30	0.069	204.6
	6	2.90	239778	95033	2.50	0.072	213.3
	average	2.72	239124	100081	2.40	0.063	187.2
EX. 7	1	2.50	—	—	—	0.089	263.7
	2	2.60	—	—	—	0.099	293.2
	3	2.50	—	—	—	0.099	293.3
	4	2.70	—	—	—	0.094	278.4
	5	2.90	—	—	—	0.092	272.5
	6	2.70	—	—	—	0.086	254.8
	average	2.65	—	—	—	0.093	276.0
EX. 8	1	3.10	—	—	—	0.116	360.8
	2	2.90	—	—	—	0.120	372.4
	3	2.60	—	—	—	0.115	413.1
	4	3.30	—	—	—	0.108	319.9
	5	3.30	—	—	—	0.120	434.2
	6	3.00	—	—	—	0.115	416.3
	average	3.03	—	—	—	0.116	386.1
EX. 9	1	3.50	—	—	—	0.093	275.5
	2	2.70	—	—	—	0.107	317.0
	3	3.10	—	—	—	0.094	278.5
	4	3.20	—	—	—	0.105	321.3
	5	3.00	—	—	—	0.108	319.9
	average	3.10	—	—	—	0.101	302.4
EX. 10	1	3.70	—	—	—	0.124	771.2
	2	3.50	—	—	—	0.122	819.4
	3	3.30	—	—	—	0.119	765.3
	4	3.60	—	—	—	0.120	674.4
	5	3.30	—	—	—	0.121	785.1
	6	3.30	—	—	—	0.109	829.8

		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
	average	3.45	—	—	—	0.119	774.2
EX. 11	1	3.10	—	—	—	0.117	373.0
	2	3.20	—	—	—	0.119	470.9
	3	3.10	—	—	—	0.101	511.4
	4	3.50	—	—	—	0.121	358.4
	5	3.00	—	—	—	0.109	546.0
	6	2.60	—	—	—	0.113	355.4
	average	3.08	—	—	—	0.113	435.9
EX. 12	1	3.40	—	—	—	0.126	1033.2
	2	4.10	—	—	—	0.125	958.0
	3	3.80	—	—	—	0.122	1059.7
	4	4.00	—	—	—	0.128	1337.2
	5	3.50	—	—	—	0.122	1417.4
	6	3.90	—	—	—	0.125	1302.8
	average	3.78	—	—	—	0.125	1184.7

Table 2. Polymerizations via (1,3-MeBuCp)₂ZrMe₂.

	Catalyst	Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
Ex. 13	1	3.00	416906	245276	1.70	0.112	331.7
	2	2.90	407630	238691	1.70	0.107	316.9
	3	2.90	408000	240761	1.70	0.101	299.2
	4	3.00	403895	226295	1.80	0.087	257.7
	5	2.90	414917	241575	1.70	0.092	272.6
	6	2.90	432281	211815	2.00	0.094	278.4
	average	2.93	417031	226562	1.83	0.091	269.6
EX. 14	1	2.50	489945	241860	2.00	0.062	183.6
	2	2.60	502925	241499	2.10	0.064	189.6
	3	2.60	496060	269711	1.80	0.061	180.7

PATENT
Attorney Docket No.: 2001-017 (UNIV/0017)
Express Mail No.: EV 349850690 US

Catalyst		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
	4	2.70	473705	224551	2.10	0.079	234.0
	5	2.70	456552	244240	1.90	0.093	275.4
	6	2.80	482871	253670	1.90	0.077	228.1
	average	2.73	471043	240821	1.97	0.083	245.9
EX. 15	1	2.80	452569	244160	1.90	0.098	290.3
	2	2.70	470026	233528	2.00	0.111	328.7
	3	2.90	461691	227846	2.00	0.101	299.2
	4	2.70	442421	211317	2.10	0.093	275.5
	5	3.00	449904	230686	2.00	0.105	311.0
	6	3.10	457789	252254	1.80	0.099	298.1
	average	2.93	450038	231419	1.97	0.099	294.9
EX. 16	1	2.90	460248	217842	2.10	0.097	287.3
	2	2.80	460812	247874	1.90	0.110	352.7
	3	2.80	453680	237861	1.90	0.102	302.1
	4	2.90	447407	233535	1.90	0.104	308.1
	5	3.00	468014	259031	1.80	0.113	417.1
	average	2.88	458032	239229	1.92	0.105	333.4
EX. 17	1	2.70	476055	280096	1.70	0.086	254.8
	2	2.60	489163	288647	1.70	0.084	248.8
	3	2.60	490692	283332	1.70	0.079	234.0
	4	3.10	461382	278104	1.70	0.098	290.3
	5	2.50	459607	271872	1.70	0.114	337.6
	6	2.60	483193	290525	1.70	0.107	317.0
	average	2.68	476682	282096	1.70	0.095	280.4
EX. 18	1	2.90	415629	254208	1.60	0.119	435.4
	2	2.80	431331	248591	1.70	0.118	471.9
	3	3.10	400328	243161	1.60	0.124	544.4
	4	2.90	416159	255835	1.60	0.123	553.6
	5	2.80	428613	255333	1.70	0.119	591.3
	average	2.90	418412	251426	1.64	0.121	519.3

Catalyst		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
EX. 19	1	2.70	399052	244978	1.60	0.124	539.4
	2	3.00	415499	255272	1.60	0.124	597.7
	3	2.60	361000	216399	1.70	0.122	595.4
	4	2.70	351678	208427	1.70	0.121	562.9
	5	2.90	344540	202559	1.70	0.124	705.7
	average	2.78	374354	225527	1.66	0.123	600.2

Table 3. Polymerizations via (1,3-Me,BuCp)₂ZrMe₂

Catalyst		Co-monomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
EX. 20	1	3.10	484463	247100	2.00	0.056	165.9
	2	3.00	499393	222881	2.20	0.064	189.5
	3	3.10	508096	278238	1.80	0.069	204.4
	average	3.07	497317	249406	2.00	0.063	186.6
EX. 21	1	3.20	402144	204908	2.00	0.115	385.7
	2	3.30	400140	216173	1.90	0.125	458.7
	3	3.80	467563	245489	1.90	0.112	406.8
	average	3.43	423282	222190	1.93	0.117	417.1
EX. 22	1	—	—	—	—	0.013	38.5
	2	—	—	—	—	0.014	41.5
	3	4.90	581327	278868	2.10	0.015	44.4
	average	4.90	581327	278868	2.10	0.014	41.5
EX. 23	1	3.10	424009	71408	5.90	0.126	714.4
	2	3.10	425483	185344	2.30	0.126	678.3
	3	3.30	442826	249234	1.80	0.122	654.0
	average	3.17	430773	168662	3.33	0.125	682.2
EX. 24	1	3.50	409086	229829	1.80	0.126	854.6

Catalyst		Co-monomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
	2	3.30	423076	241300	1.80	0.130	1041.7
	3	4.40	433486	175740	2.50	0.034	256.5
	average	3.73	421883	215623	2.03	0.097	717.6
EX. 25	1	3.10	412221	115877	3.60	0.120	355.5
	2	2.90	478218	265081	1.80	0.110	404.9
	3	3.00	494092	249776	2.00	0.121	365.9
	average	3.00	461510	210245	2.47	0.117	375.4
EX. 26	1	3.10	455400	249740	1.80	0.115	452.0
	2	3.00	462092	249919	1.80	0.118	587.2
	3	2.90	452498	223762	2.00	0.107	513.9
	average	3.00	456663	241140	1.87	0.113	517.7
EX. 27	1	3.10	387341	207282	1.90	0.126	965.5
	2	3.00	378827	208824	1.80	0.130	1048.3
	3	2.80	395727	215035	1.80	0.134	1223.5
	average	2.97	387299	210380	1.83	0.130	1079.1

COMPARATIVE EXAMPLE 1:

[00361] Silica supported (1,3-MeBuCp)₂ZrCl₂, activated with MAO, was prepared in accordance with the method outlined in the examples of U.S. Patent No. 5,712,352. The polymerization results are shown below in Table 4.

Table 4.

		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
Comp. EX. 1	1	2.30	331144	180960	1.80	0.128	660.4
	2	2.90	346637	135216	2.60	0.103	574.0
	3	2.50	337057	182777	1.80	0.129	646.0
	4	2.30	330231	151962	2.20	0.121	613.2
	5	2.30	321915	186250	1.70	0.122	681.2
	6	2.40	339836	191126	1.80	0.128	780.3
	average	2.45	334470	171382	1.98	0.122	659.2

COMPARATIVE EXAMPLE 2:

[00362] 4.0 grams of a 10 wt% solution of ethylaluminumoxane in heptane was combined with 1.0 grams of silica (Davison 948 calcined at 600°C) in a 100 mL flask. The resulting slurry was allowed to sit overnight. The resulting silica was filtered, and rinsed with several 10 mL portions of toluene. 0.20 grams of tris(perfluorophenyl)borane was added to the silica, slurried in o-xylene and heated to 130°C for three hours. The silica was then filtered, rinsed with several 10 mL portions of toluene, and subsequently combined with 0.09 grams of (1,3-MeBuCp)₂ZrMe₂ solution. The supported catalyst was allowed to sit at room temperature for 1 hr. The catalyst was filtered, rinsed with several 10 mL portions of toluene, and dried under a vacuum. The polymerization results are shown below in Table 5.

Table 5.

		Comonomer Incorporation	Average Mw	Average Mn	Average PDI	Yield	Activity (gP/gCat*hr)
Comp. EX. 2	1	2.8	459215.9	209129	2.2	0.052	154.0
	2	2.6	476909.6	229259	2.1	0.043	127.4
	3	2.6	470312.3	237023	2	0.043	127.4
	average	2.7	468813	225137	2.1	0.046	136.3

[00363] Unless otherwise indicated, all numbers expressing quantities of ingredients, properties, reaction conditions, and so forth, used in the specification and claims are to be understood as approximations based on the desired properties sought to be obtained by the present invention, and the error of measurement, etc., and should at least be construed in light of the number of reported significant digits and by applying ordinary rounding techniques. Notwithstanding that the numerical ranges and values setting forth the broad scope of the invention are approximations, the numerical values set forth are reported as precisely as possible.

[00364] All priority documents are herein fully incorporated by reference for all jurisdictions in which such incorporation is permitted. Further, all documents cited herein, including testing procedures, are herein fully incorporated by reference for all jurisdictions in which such incorporation is permitted.

[00365] While the foregoing is directed to embodiments of the present invention, other and further embodiments of the invention may be devised without departing from the basic scope thereof, and the scope thereof is determined by the claims that follow.